Grizzly Industrial, Inc.®

MODEL G0605X1/G0606X1/ G0696X/G0697X/ 12" LEFT TILTING TABLE SAW

OWNER'S MANUAL

(FOR MACHINES MANUFACTURED FROM 10/08 AND LATER)

Model G0606X1

Model G0697X

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⚠ WARNING!

This manual provides critical safety instructions on the proper setup, operation, maintenance and service of this machine/equipment.

Failure to read, understand and follow the instructions given in this manual may result in serious personal injury, including amputation, electrocution or death.

The owner of this machine/equipment is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, blade/cutter integrity, and the usage of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.

⚠ WARNING!

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- **Lead from lead-based paints.**
- **Crystalline silica from bricks, cement and other masonry products.**
- **Arsenic and chromium from chemically-treated lumber.**

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

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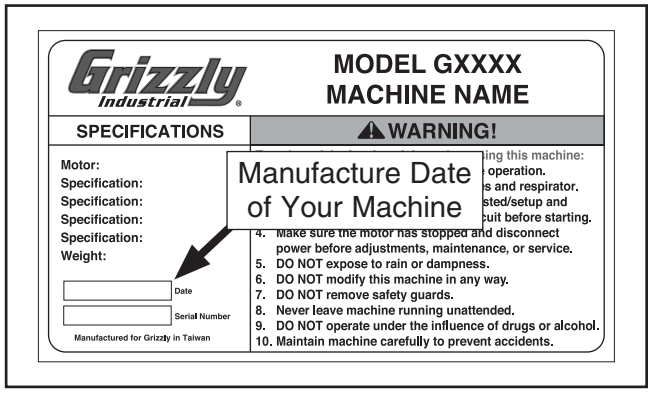
INTRODUCTION

Manual Accuracy

We are proud to offer this manual with your new machine! We've made every effort to be exact with the instructions, specifications, drawings, and photographs of the machine we used when writing this manual. However, sometimes errors do happen and we apologize for them.

Also, owing to our policy of continuous improvement, **your machine may not exactly match the manual**. If you find this to be the case, and the difference between the manual and machine leaves you in doubt, check our website for the latest manual update or call technical support for help.

Before calling, find the manufacture date of your machine by looking at the date stamped into the machine ID label (see below). This will help us determine if the manual version you received matches the manufacture date of your machine.



For your convenience, we post all available manuals and manual updates for free on our website at **www.grizzly.com**. Any updates to your model of machine will be reflected in these documents as soon as they are complete.

Contact Info

We stand behind our machines. If you have any service questions, parts requests or general questions about the machine, please call or write us at the location listed below.

Grizzly Industrial, Inc.
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Fax: (800) 438-5901
E-Mail: techsupport@grizzly.com

If you have any comments regarding this manual, please write to us at the address below:

Grizzly Industrial, Inc.
C/O Technical Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069
Email: manuals@grizzly.com

Machine Description

The table saw is a circular sawing machine that excels at making straight cuts quickly and accurately. The blade is mounted underneath the table and can be raised or lowered to expose more or less of the blade to control the cutting depth. The blade can also be tilted to cut bevels or angles.

The table saw uses a fence, which is parallel with the blade, as the primary method of guiding the workpiece through a cut. Additionally, the table saw table is equipped with T-slots that are also parallel with the blade and are used to guide a miter gauge for operations that cannot be safely done by using the fence.

Since part of the moving blade is exposed during operations, the table saw is equipped with a blade guard to reduce the risk of injury. The table saw is one of the most useful machines in the woodshop, but it is also one of the most dangerous. Therefore, it should always be used with respect and care by only well-trained individuals.

Identification

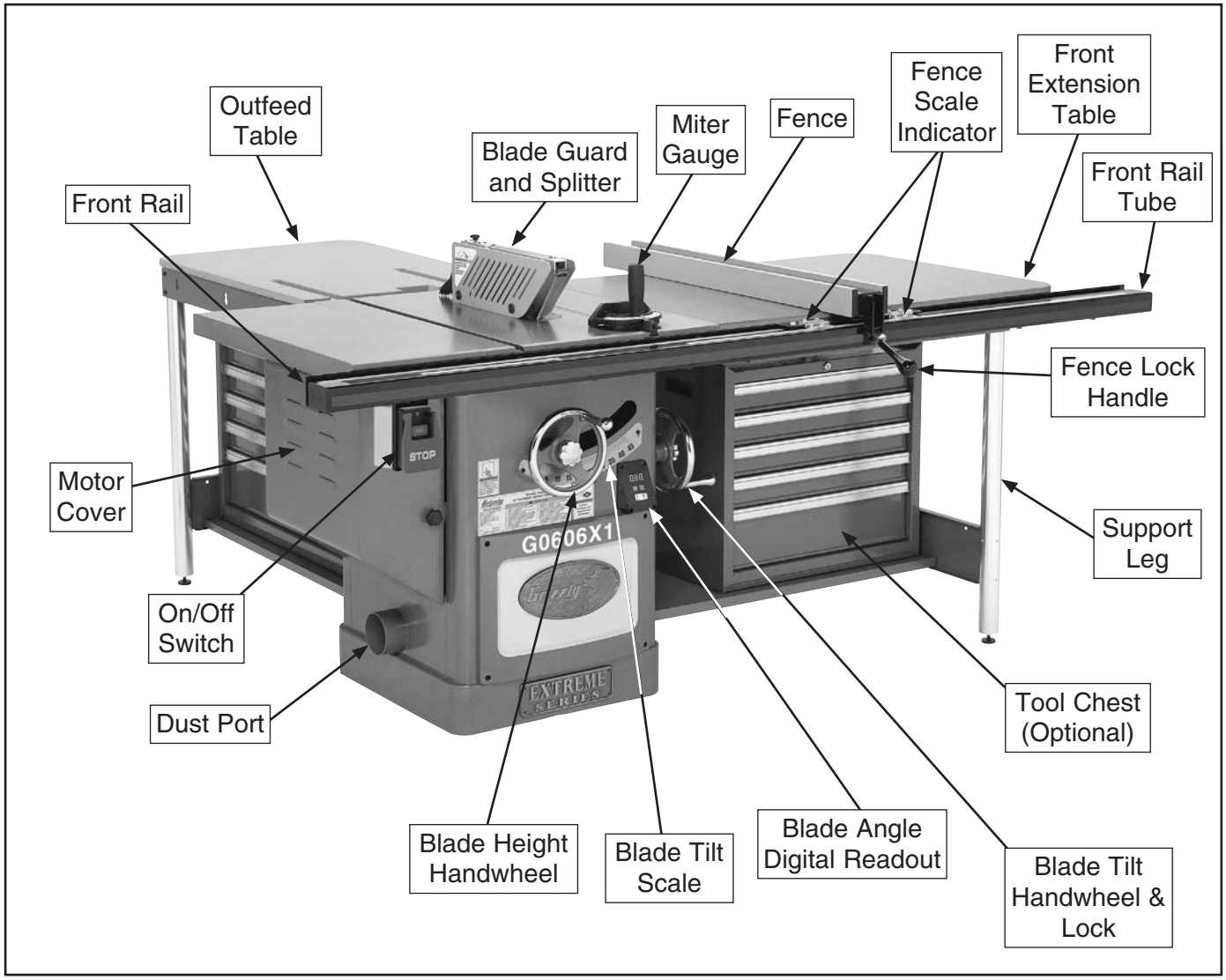


Figure 1. G0606X1 identification.

MACHINE DATA SHEET

Customer Service #: (570) 546-9663 • To Order Call: (800) 523-4777 • Fax #: (800) 438-5901

MODEL G0605X1/G0606X1/G0696X/G0697X
12" LEFT-TILTING TABLE SAWS

Model Number	G0605X1	G0606X1	G0696X	G0697X
Motor	5 HP	7½ HP	5 HP	7½ HP
Voltage	220V	220V/440V	220V	220V/440V
Phase	Single-Phase	Three-Phase	Single-Phase	Three-Phase
Amps	24	20/10	24	20/10
Speed	3450 RPM	3450 RPM	3450 RPM	3450 RPM
Table Size (full assembly)	78¾" x 30¾"	78¾" x 30¾"	30¾" x 48¾"	30¾" x 48¾"
Table Height Above Floor	35¾"	35¾"	35¾"	35¾"
Overall Machine Size	93"L x 91"W	93"L x 91"W	75"L x 44"W	75"L x 44"W
Footprint Size	22½"L x 24"W	22½"L x 24"W	22½"L x 24"W	22½"L x 24"W
Weight	715 lbs.	715 lbs.	640 lbs.	640 lbs.
Fence Type	T-Shape	T-Shape	T-Shape	T-Shape
Extension & Outfeed Tables	Yes	Yes	No	No
Maximum Rip Right of Blade	52"	52"	36"	36"
Maximum Rip Left of Blade	18"	18"	18"	18"
Maximum Depth of Cut at 90°	4"	4"	4"	4"
Maximum Depth of Cut at 45°	2¾"	2¾"	2¾"	2¾"
Maximum Blade Diameter	12"	12"	12"	12"
Arbor Size	⅝" & 1"	⅝" & 1"	⅝" & 1"	⅝" & 1"
Arbor Speed	3600 RPM	3600 RPM	3600 RPM	3600 RPM
Rim Speed	11,310 FPM	11,310 FPM	11,310 FPM	11,310 FPM
Blade Tilt (Left)	0° – 45°	0° – 45°	0° – 45°	0° – 45°
Maximum Dado Width	¾"	¾"	¾"	¾"
Miter Slot Size	¾"W x ⅜"H	¾"W x ⅜"H	¾"W x ⅜"H	¾"W x ⅜"H
Dust Port Size	4"	4"	4"	4"
Country of Origin	Taiwan	Taiwan	Taiwan	Taiwan
Assembly Time (approx.)	75 Minutes	75 Minutes	60 Minutes	60 Minutes
Warranty	1 Year	1 Year	1 Year	1 Year

SECTION 1: SAFETY

⚠WARNING

For Your Own Safety, Read Instruction Manual Before Operating this Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.

⚠DANGER **Indicates an imminently hazardous situation which, if not avoided, WILL result in death or serious injury.**

⚠WARNING **Indicates a potentially hazardous situation which, if not avoided, COULD result in death or serious injury.**

⚠CAUTION **Indicates a potentially hazardous situation which, if not avoided, MAY result in minor or moderate injury. It may also be used to alert against unsafe practices.**

NOTICE **This symbol is used to alert the user to useful information about proper operation of the machine.**

⚠WARNING

Safety Instructions for Machinery

1. **READ THE ENTIRE MANUAL BEFORE STARTING MACHINERY.** Machinery presents serious injury hazards to untrained users.
2. **ALWAYS USE ANSI APPROVED SAFETY GLASSES WHEN OPERATING MACHINERY.** Everyday eyeglasses only have impact resistant lenses—they are NOT safety glasses.
3. **ALWAYS WEAR A NIOSH APPROVED RESPIRATOR WHEN OPERATING MACHINERY THAT PRODUCES DUST.** Most types of dust (wood, metal, etc.) can cause severe respiratory illnesses.
4. **ALWAYS USE HEARING PROTECTION WHEN OPERATING MACHINERY.** Machinery noise can cause permanent hearing loss.
5. **WEAR PROPER APPAREL.** DO NOT wear loose clothing, gloves, neckties, rings, or jewelry that can catch in moving parts. Wear protective hair covering to contain long hair and wear non-slip footwear.
6. **NEVER OPERATE MACHINERY WHEN TIRED OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Be mentally alert at all times when running machinery.

⚠WARNING
Safety Instructions for Machinery

7. **ONLY ALLOW TRAINED AND PROPERLY SUPERVISED PERSONNEL TO OPERATE MACHINERY.** Make sure operation instructions are safe and clearly understood.

8. **KEEP CHILDREN AND VISITORS AWAY.** Keep all children and visitors a safe distance from the work area.

9. **MAKE WORKSHOP CHILDPROOF.** Use padlocks, master switches, and remove start switch keys.

10. **NEVER LEAVE WHEN MACHINE IS RUNNING.** Turn power ***OFF*** and allow all moving parts to come to a complete stop before leaving machine unattended.

11. **DO NOT USE IN DANGEROUS ENVIRONMENTS.** DO NOT use machinery in damp, wet locations, or where any flammable or noxious fumes may exist.

12. **KEEP WORK AREA CLEAN AND WELL LIGHTED.** Clutter and dark shadows may cause accidents.

13. **USE A GROUNDED EXTENSION CORD RATED FOR THE MACHINE AMPERAGE.** Grounded cords minimize shock hazards. Undersized cords create excessive heat. Always replace damaged extension cords.

14. **ALWAYS DISCONNECT FROM POWER SOURCE BEFORE SERVICING MACHINERY**. Make sure switch is in OFF position before reconnecting.

15. **MAINTAIN MACHINERY WITH CARE.** Keep blades sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

16. **MAKE SURE GUARDS ARE IN PLACE AND WORK CORRECTLY BEFORE USING MACHINERY.**

17. **REMOVE ADJUSTING KEYS AND WRENCHES.** Make a habit of checking for keys and adjusting wrenches before turning machinery ***ON***.

18. **CHECK FOR DAMAGED PARTS BEFORE USING MACHINERY.** Check for binding or misaligned parts, broken parts, loose bolts, and any other conditions that may impair machine operation. Repair or replace damaged parts before operation.

19. **USE RECOMMENDED ACCESSORIES.** Refer to the instruction manual for recommended accessories. Improper accessories increase risk of injury.

20. **DO NOT FORCE MACHINERY.** Work at the speed for which the machine or accessory was designed.

21. **SECURE WORKPIECE.** Use clamps or a vise to hold the workpiece when practical. A secured workpiece protects your hands and frees both hands to operate the machine.

22. **DO NOT OVERREACH.** Maintain stability and balance at all times.

23. **MANY MACHINES CAN EJECT WORKPIECES TOWARD OPERATOR.** Know and avoid conditions that cause the workpiece to "kickback."

24. **ALWAYS LOCK MOBILE BASES (IF USED) BEFORE OPERATING MACHINERY**.

25. **CERTAIN DUST MAY BE HAZARDOUS** to the respiratory systems of people and animals, especially fine dust. Be aware of the type of dust you are exposed to and always wear a respirator designed to filter that type of dust.

⚠WARNING
Safety Instructions for Table Saws

1. **SAFETY GUARDS.** Always use the blade guard and splitter on "through-sawing" operations, where the blade cuts completely through the top of the workpiece. Always use a riving knife for non-through cuts.

2. **KICKBACK.** Be familiar with kickback. Kickback happens when the workpiece is thrown towards the operator at a high rate of speed. *Until you have a clear understanding of kickback and how it occurs, DO NOT operate this table saw!*

3. **REACHING OVER SAW BLADE.** Never reach behind or over the blade while the saw is running; *hands or arms will be pulled into the saw blade if kickback occurs.*

4. **WORKPIECE CONTROL.** Make sure the workpiece is stable on the table and is supported by the rip fence or the miter gauge during cutting operations. DO NOT perform any cutting operations free-hand.

5. **SAFETY ACCESSORIES.** Use push sticks, hold-downs, featherboards, and other devices to increase cutting safety.

6. **OPERATOR POSITION.** Never stand or have any part of your body directly in-line with the cutting path of the saw blade. Avoid operations and hand positions where a slip could cause your hand to move into the blade.

7. **CUT-OFF PIECES.** Turn saw ***OFF*** and allow blade to stop before removing workpiece cutoffs.

8. **CROSSCUTTING OPERATIONS.** Remove the rip fence whenever using the miter gauge to crosscut a workpiece.

9. **BLADE HEIGHT.** Always adjust the blade to the proper height above the workpiece.

10. **WORKPIECE SUPPORT.** Provide adequate support to the rear and sides of the saw table for wide or long workpieces.

11. **DAMAGED SAW BLADES.** Never use blades that have been dropped or otherwise damaged.

12. **DADO AND RABBET OPERATIONS.** Dado and rabbeting operations require special attention because those operations must be performed with the blade guard removed. DO NOT attempt these operations without first reading the sections in this manual on those specific operations.

13. **CUTTING CORRECT MATERIAL.** This machine is intended for cutting natural and man-made wood products, laminate covered wood products, and some plastics. This machine is NOT designed to cut metal, glass, stone, tile, etc.; cutting these materials with a table saw may lead to injury.

14. **EXPERIENCING DIFFICULTIES.** If at any time you are experiencing difficulties performing the intended operation, stop using the machine! Contact our Service Department at (570) 546-9663.

⚠WARNING

Like all machinery there is potential danger when operating this machine. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

⚠CAUTION

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.

Preventing Kickback

Below are tips to avoid the most common causes of kickback:

- Only cut workpieces with at least one smooth and straight edge. DO NOT cut warped, cupped or twisted wood.
- Never attempt freehand cuts. If the workpiece is not fed parallel with the blade, kickback will likely occur. Always use the rip fence or miter gauge to support the workpiece.
- Make sure the splitter or riving knife is aligned with the blade. A misaligned splitter or riving knife can cause the workpiece to catch or bind, increasing the chance of kickback. If you think that your splitter or riving knife is not aligned with the blade, check it immediately!
- Take the time to check and adjust the rip fence parallel with the blade; otherwise, the chances of kickback are extreme.
- The splitter or riving knife maintains the kerf in the workpiece, reducing the chance of kickback. Always use the riving knife for all non-through operations, unless a dado blade is installed. Always use the splitter with the blade guard for all through cuts.
- Feed cuts through to completion. Anytime you stop feeding a workpiece in the middle of a cut, the chance of kickback is greatly increased.
- Keep the blade guard installed and in good working order. Only remove it when performing non-through cuts and immediately re-install the blade guard when finished. Remember, always use the riving knife for all non-through operations, unless a dado blade is installed.
- Make multiple, shallow passes when performing a non-through cut. Making a deep non-through cut will greatly increase the chance of kickback.

⚠WARNING

Statistics show that most common accidents among table saw users can be linked to kickback. Kickback is typically defined as the high-speed expulsion of stock from the table saw toward the operator. In addition to the danger of the operator or others in the area being struck by the flying stock, the operator's hands could be pulled into the blade during the kickback.

Protecting Yourself From Kickback

Even if you know how to prevent kickback, it may still happen. Here are some tips to protect yourself if kickback DOES occur:

- Stand to the side of the blade during every cut. If kickback does occur, the thrown workpiece usually travels directly in front of the blade.
- Wear safety glasses or a face shield. In the event of kickback, your eyes and face are the most vulnerable part of your body.
- Never, for any reason, place your hand behind the blade. Should kickback occur, your hand will be pulled into the blade.
- Use a push stick to keep your hands farther away from the moving blade. If kickback occurs, the push stick will most likely take the damage that your hand would have received.
- Use featherboards or anti-kickback devices such as Board Buddies (see **Accessories** on **Page 47**) to prevent or slow down kickback.

Glossary of Terms

The following is a list of common definitions, terms and phrases used throughout this manual as they relate to this table saw and woodworking in general. Become familiar with these terms for assembling, adjusting or operating this machine. Your safety is **VERY** important to us at Grizzly!

Arbor: A metal shaft extending from the drive mechanism that is the mounting location for the saw blade.

Bevel Edge Cut: A straight cut made with the blade tilted to an angle between 0˚ and 45˚. Refer to **Page 38** for more details.

Blade Guard Assembly: Metal or plastic safety device that mounts over the saw blade. Its function is to prevent the operator from coming into contact with the saw blade. Refer to **Page 31** for more details.

Crosscut: Cutting operation in which the crosscut fence is used to cut across the shortest width of the workpiece. Refer to **Page 37** for more details.

Dado Blade: Blade or set of blades that are used to cut grooves and rabbets. Refer to **Page 47** for more details. **DO NOT use a dado blade larger than 12" in diameter on this saw!** The saw and arbor are not intended to safely use a larger dado blade.

Dado Cut: Cutting operation that uses a dado blade to cut a flat bottomed groove into the face of the workpiece. Refer to **Page 38** for more details.

Featherboard: Safety device used to keep the workpiece against the rip fence and against the table surface. Refer to **Page 48** for more details.

Kerf: The resulting cut or gap in the workpiece after the saw blade passes through the workpieces.

Kickback: An event in which the workpiece is propelled back towards the operator at a high rate of speed.

Non-Through Cut: A cut in which the blade does not cut through the top of the workpiece. Refer to **Page 30** for more details.

Parallel: Being an equal distance apart at every point along two given lines or planes (i.e., the rip fence face is parallel with the face of the saw blade).

Perpendicular: Lines or planes that intersect and form right angles (i.e., the blade is perpendicular to the table surface).

Push Stick: Safety device used to push the workpiece through a cutting operation. Used most often when rip cutting thin workpieces. Refer to **Page 48** for more details.

Rabbet: Cutting operation that creates an L-shaped channel along the edge of the workpiece. Refer to **Page 40** for more details.

Rip Cut: Cutting operation in which the rip fence is used to cut across the widest width of the workpiece. Refer to **Page 36** for more details.

Riving Knife: Metal plate located behind the blade. It maintains the kerf opening in the wood when performing a cutting operation. Refer to **Page 32** for more details.

Straightedge: A tool used to check the flatness, parallelism, or consistency of a surface(s).

Thin Kerf Blade: A blade with a kerf or thickness that is thinner than a standard blade. Since thin kerf blades are typically the same thickness of the splitter or riving knife—and in some cases thinner—we DO NOT recommend that they be used on this saw due to the increased risk of kickback.

Through Cut: A cut in which the blade cuts completely through the workpiece. Refer to **Page 30** for more details.

SECTION 2: CIRCUIT REQUIREMENTS

WARNING

Serious personal injury could occur if you connect the machine to power before completing the setup process. DO NOT connect the machine to the power until instructed later in this manual.

WARNING

Electrocution or fire could result if machine is not grounded and installed in compliance with electrical codes. Compliance MUST be verified by a qualified electrician!

NOTICE

The Model G0697X/G0606X1 is prewired for 220V operation. If you plan to use your machine at 440V, you MUST have a qualified electrican perform the 440V conversion described on Page 11.

Full Load Amperage Draw Draw

G0605X1/G0696X.....24 Amps
G0606X1/G0697X @ 220V .....20 Amps
G0606X1/G0697X @ 440V .....10 Amps

Power Supply Circuit Requirements

The power supply circuit for your machine MUST be grounded and rated for the amperage given below. Never replace a circuit breaker on an existing circuit with one of higher amperage without consulting a qualified electrician to ensure compliance with wiring codes. **If you are unsure about the wiring codes in your area or you plan to connect your machine to a shared circuit, consult a qualified electrician.**

G0605X1/G0696X @ 220V .....30 Amps
G0606X1/G0697X @ 220V .....30 Amps
G0606X1/G0697X @ 440V ..... 15 Amps

Power Connection Device

The power connection device depends on the type of installed or planned service. We recommend using one of the devices shown in **Figure 2**, depending on the voltage being used.

G0605X1/G0696X @220V Single-Phase .. L6-30
G0606X1/G0697X @220V 3-Phase L15-30
G0606X1/G0697X @440V 3-Phase ... Hardwired
Locking Disconnect Switch

For 440V connections, an electrician MUST hardwire the machine (using a metal conduit setup) directly to a locking disconnect switch, which is directly connected to the power source.

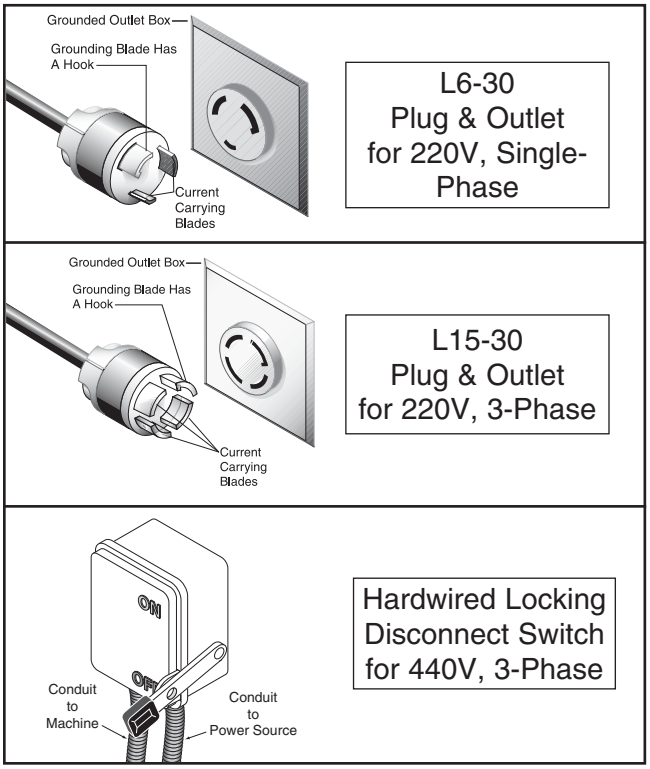

Grounded Outlet Box
Grounding Blade Has A Hook
Current Carrying Blades
L6-30 Plug & Outlet for 220V, Single-Phase
Grounded Outlet Box
Grounding Blade Has A Hook
Current Carrying Blades
L15-30 Plug & Outlet for 220V, 3-Phase
On
Off
Conduit to Machine
Conduit to Power Source
Hardwired Locking Disconnect Switch for 440V, 3-Phase

Figure 2. Recommended connection types.

Extension Cords (220V Only)

Using extension cords may reduce the life of the motor. Instead, place the machine near a power source. If you must use an extension cord:

- Use at least a 10 gauge cord that does not exceed 50 feet in length.
- Ensure that the extension cord contains a ground wire and plug pin.

Phase Converter Precaution

The power from the manufactured leg may damage electrical components if connected to the wrong incoming power terminal on your machine. Only connect the manufactured leg to the **L2** terminal (see **Page 69** for identification). **DO NOT use a static phase converter, as they notoriously damage electrical components.**

440V Conversion

The Model G0606X1/G0697X can be converted for 440V operation.

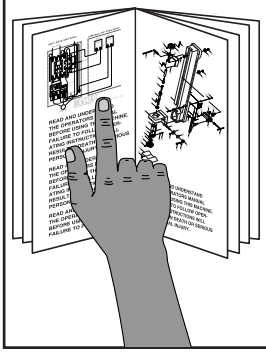
All wiring changes must be inspected by a qualified electrician before the saw is connected to the power source. If, at any time during this procedure you need help, call Grizzly Tech Support at (570) 546-9663.

To rewire the Model G0606X1/G0697X:

1. DISCONNECT THE SAW FROM POWER!
2. Open the motor cover.
3. Remove the motor junction box cover, rewire the motor as shown on the diagram located inside the junction box, then reinstall the cover.

   Note: *The reference wiring diagram on* **Page 70** *was current at the time of printing, but always use the wiring diagram provided inside the motor junction box, as it will reflect any changes to the motor shipped with your machine.*
4. Remove the magnetic switch cover and move the fuse on the fuse block from the 220V slot to the 440V slot (refer to the photos on **Page 68** and wiring diagram on **Page 70** for wiring details.
5. Turn the thermal overload relay dial from 20 to 10 Amps.
6. Reinstall the magnetic switch cover and close and secure the motor cover.

SECTION 3: SETUP



⚠WARNING

This machine presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before starting the machine!

⚠WARNING

Wear safety glasses during the entire setup process!

⚠WARNING

This machine and its components are very heavy. Get lifting help or use power lifting equipment such as a forklift to move heavy items.

Items Needed for Setup

The following items are needed to complete the setup process, but are not included with your machine:

Description	Qty
• Safety Glasses for Each Person	1
• Cleaner/Degreaser (**Page 18**)	As Needed
• Disposable Shop Rags	As Needed
• Forklift	1
• Additional People	1
• Straightedge 12" (or longer)	1
• Straightedge 36" (or longer)	1
• Level	1
• Open-End Wrench 12mm	1
• Dust Collection System	1
• Dust Hose 4"	1
• Hose Clamp 4"	1
• Piece of Scrap Wood	1

Unpacking

Your machine was carefully packaged for safe transportation. Remove the packaging materials from around your machine and inspect it. If you discover the machine is damaged, *please immediately call Customer Service at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, inventory the contents.

G0605X1/G0606X1 Inventory

The following is a description of the main components shipped with each Model G0605X1/G0606X1. Lay the components out to inventory them.

Note: *If you can't find an item on this list, check the mounting location on the machine or examine the packaging materials carefully. Occasionally we pre-install certain components for shipping purposes.*

Table Saw Unit

Box Contents (Figure 3):		**Qty**
A.	Table Saw Unit (Not Shown)	1
B.	Splitter/Guard Assembly	1
C.	Miter Gauge Handle	1
D.	Miter Gauge	1
E.	Handwheel Handles	2
F.	Fence Resting Brackets	2
G.	Arbor Wrenches	2
H.	Arbor Extension 5/8"-12 x 1 1/4"	1
I.	Arbor Nut 5/8"-12	1
J.	Arbor Flange 5/8"	1

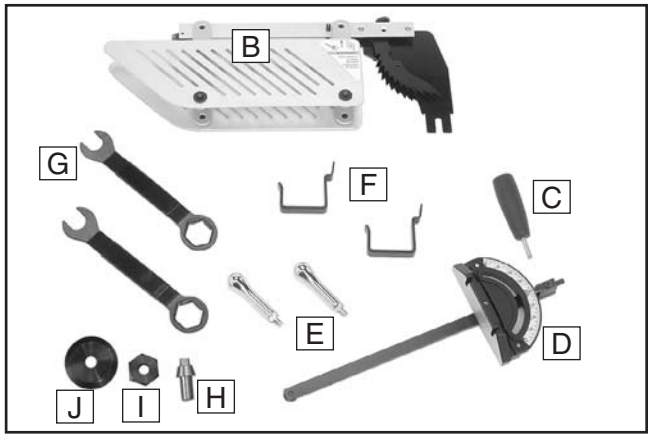


Figure 3. G0605X1 component inventory.

Hardware and Tools (Not Shown):	**Qty**
• Flat Washer 8mm (Miter Gauge)	1
• Flange Bolts M8-1.25 x 12 (Fence Resting Bracket)	2
• Flange Bolts M8-1.25 x 12 (Switch)	2
• Open-End Combo Wrenches 8 x 10, 11 x 13, 14 x 17	1 Each
• Hex Wrenches 3, 4, 5, 6mm	1 Each
• Combo Screwdriver	1
• Shims (Riving Knife/Splitter)	3

Fence Inventory

Box Contents: **(Figure 4)**		**Qty**
A.	Fence	1
B.	Fence Handle	1

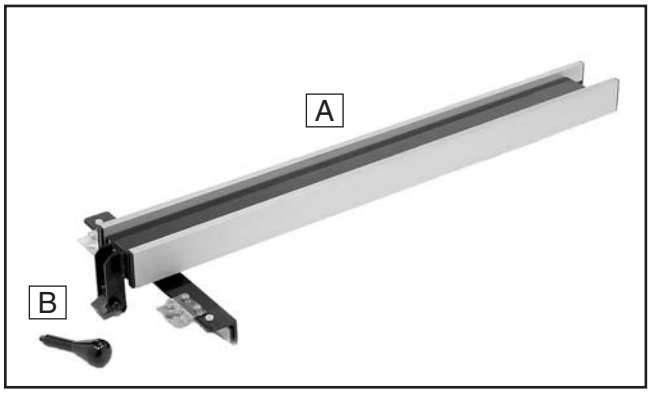


Figure 4. Fence components.

Fence Rail Inventory

Box Contents: **(Figure 5)**		**Qty**
A.	Fence Tube (91 3/8" Long)	1
B.	Front Rail (91 1/8" Long)	1
C.	Rear Rail (79" Long)	1

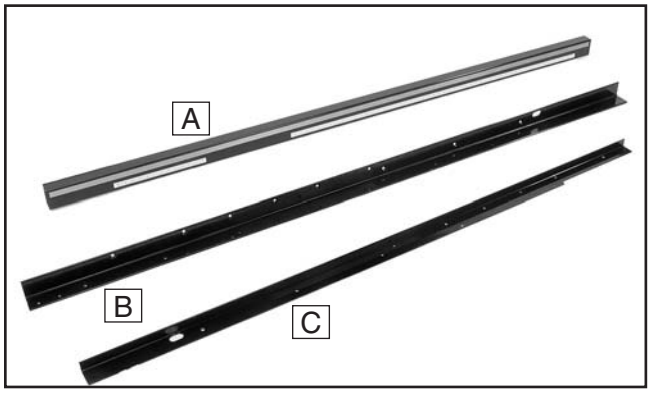
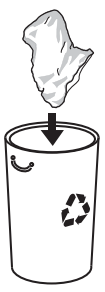


Figure 5. Fence rail components.



⚠WARNING

SUFFOCATION HAZARD!

Immediately discard all plastic bags and packing materials to eliminate choking/suffocation hazards for children and animals.

Extension Table Inventory

Box Contents: (Figure 6)	Qty
A. Extension Table	1
B. Lower Shelf	1
C. Shelf End Plate	1
D. Support Legs	2
E. Lower Shelf Brackets	2

Hardware and Tools (Not Shown):	Qty
• Cap Screws M8-1.25 x 25 (Rear Rail/Cabinet)	8
• Lock Washers 8mm (Rear Rail/Ext. Table)	10
• Flat Head Screws M8-1.25 x 25 (Front Rail/Cabinet)	8
• Flat Washers 8mm (Front Rail/Ext. Table/Rear Rail)	14
• Hex Nuts M8-1.25 (Front Rail/Ext. Table/Rear Rail)	8
• Flange Bolts M8-1.25 x 12 (Tube/ Front Rail)	9
• Hex Bolts M6-1 x 12 (Brackets/Cabinet/Legs)	4
• Hex Nuts M6-1 (Brackets/Cabinet)	2
• Feet 3/8"-16 x 2 (Legs)	2
• Phillip Head Screws M6-1 x 12 (Ext. Table/Legs/End Plate)	12
• Flat Washers 6mm (Ext Table/Legs/End Plate)	16
• Hex Nuts 3/8"-16 (Feet)	2
• Flat Washers 10mm (Cabinet)	2
• Hex Bolts M10-1.5 x 25 (Cabinet)	2

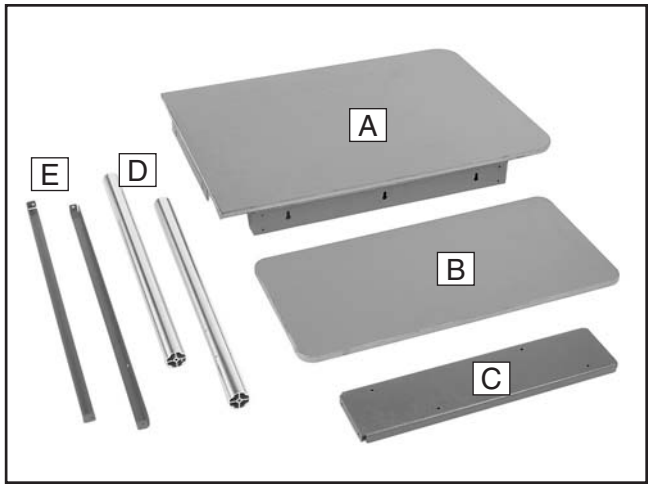


Figure 6. Extension table components.

Outfeed Table Inventory

Box Contents: (Figure 7)	Qty
A. Outfeed Table	1
B. Lower Shelf	1
C. Shelf End Plate	1
D. Support Legs	2
E. Lower Shelf Brackets	2

Hardware and Tools (Not Shown):	Qty
• Flange Bolts M8-1.25 x 16 (Rear Rail/Ext. Table)	2
• Hex Nuts M8-1.25 (Rear Rail/Ext. Table)	2
• Hex Bolts M6-1 x 12 (Brackets/Legs/Cabinet)	4
• Hex Nuts M6-1 (Bracket/Legs/Cabinet)	2
• Hex Nuts 3/8"-16 (Brackets/Legs/Cabinet)	2
• Flat Washers 6mm (Brackets/Legs/Cabinet)	16
• Phillips Head Screws M6-1 x 12 (Legs/Ext. Table/End Plate)	12
• Feet 3/8"-16 x 2 (Legs)	2

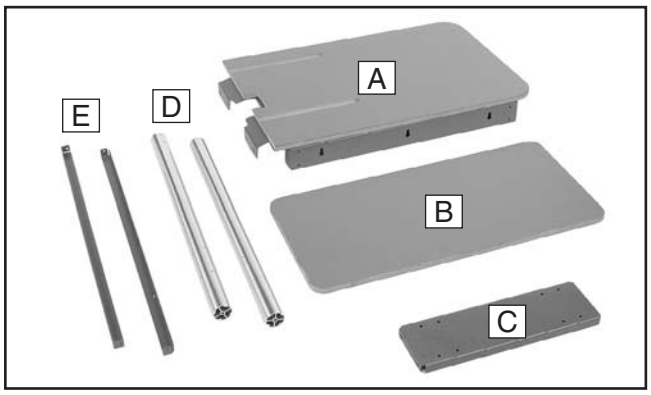


Figure 7. Outfeed table components.

If any nonproprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.

G0696X/G0697X Inventory

The following is a description of the main components shipped with each Model G0696X/G0697X. Lay the components out to inventory them.

Note: *If you can't find an item on this list, check the mounting location on the machine or examine the packaging materials carefully. Occasionally we pre-install certain components for shipping purposes.*

Table Saw Unit

Box Contents (Figures 8 & 9):		**Qty**
A.	Table Saw Unit	1
B.	Cast Iron Extension Wing	1
C.	Splitter/Guard Assembly	1
D.	Riving Knife (May Be Pre-Installed)	1
E.	Miter Gauge Handle	1
F.	Miter Gauge	1
G.	Handwheel Handles	2
H.	Fence Resting Brackets	2
I.	Arbor Wrenches	2
J.	Arbor Extension 5/8"-12 x 1 1/4"	1
K.	Arbor Nut 5/8-12	1
L.	Arbor Flange 5/8"	1

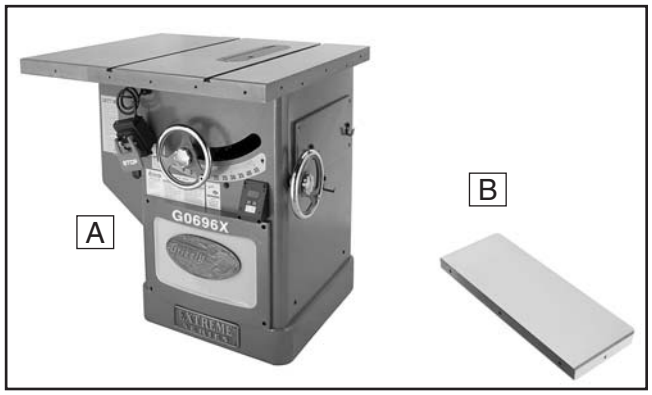


Figure 8. G0696X table saw unit.

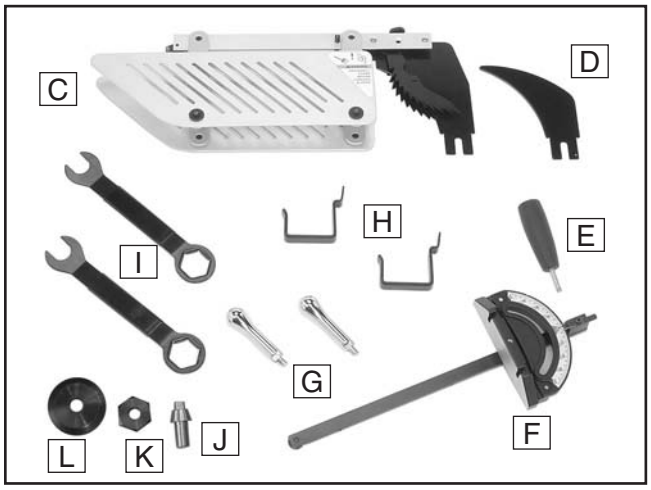


Figure 9. Main components.

Hardware and Tools (Not Shown):	**Qty**
• Flat Washer 8mm (Miter Gauge)	1
• Flange Bolts M8-1.25 x 12 (Fence Resting Bracket)	2
• Flange Bolts M8-1.25 x 12 (Switch)	2
• Open-End Combo Wrenches 8 x 10, 11 x 13, 14 x 17	1 Each
• Hex Wrenches 3, 4, 5, 6mm	1 Each
• Combo Screwdriver	1
• Shims (Riving Knife/Splitter)	3

Fence

Box Contents: **(Figure 10)**		**Qty**
A.	Fence	1
B.	Fence Handle	1

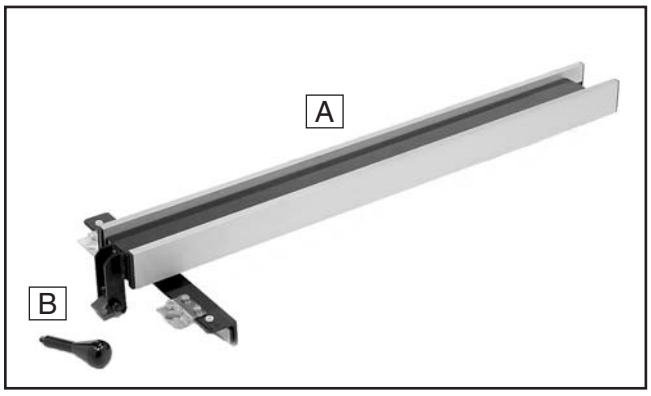


Figure 10. Fence components.

Fence Rail Inventory

Box Contents: **(Figure 11)** **Qty**

A. Fence Tube (75" Long) 1
B. Front Rail (75" Long) 1
C. Rear Rail (62½" Long)..... 1

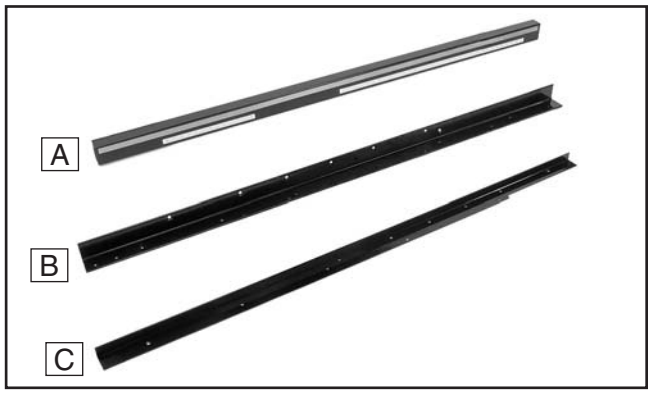


Figure 11. Fence rail components.

Hardware and Tools (Not Shown): **Qty**

- Cap Screws M8-1.25 x 25
  (Rear Rail/Cabinet/Ext. Table)..... 6
- Flat Washers 8mm
  (Rear Rail/Ext. Table) 6
- Flat Head Screws M8-1.25 x 25
  (Front Rail/Cabinet/Ext. Table) 6
- Hex Nuts M8-1.25
  (Front Rail & Rear Rails/Ext. Table) 4
- Lock Washers 8mm
  (Front & Rear Rails/Ext. Table) 10
- Flange Bolts M8-1.25 x 12
  (Fence Tube/Front Rail)..... 7
- Hex Bolts M10-1.5 x 35
  (Ext. Table) 3
- Lock Washers 10mm
  (Ext. Table) 3

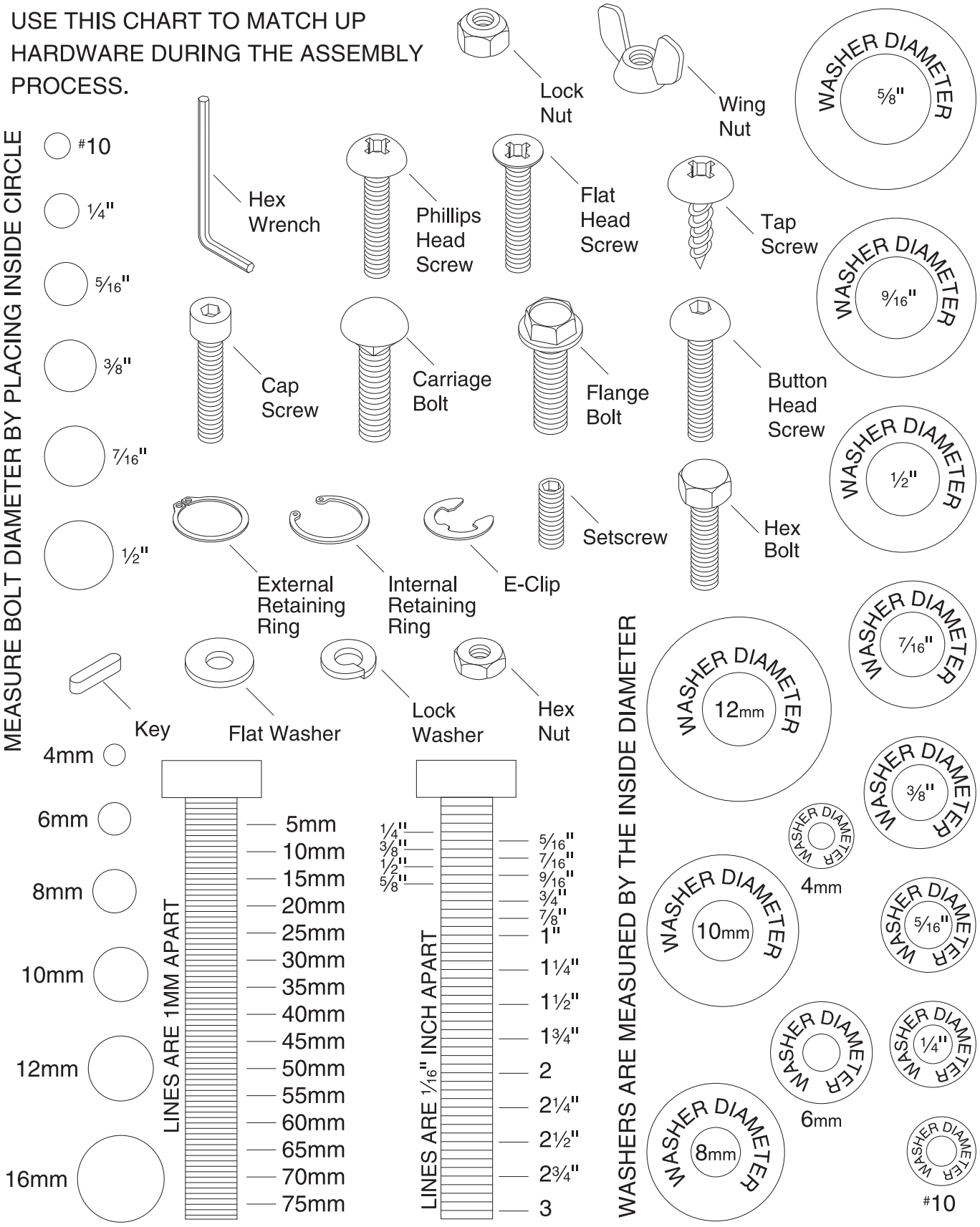
If any nonproprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.

⚠WARNING

SUFFOCATION HAZARD!
Immediately discard all plastic bags and packing materials to eliminate choking/suffocation hazards for children and animals.

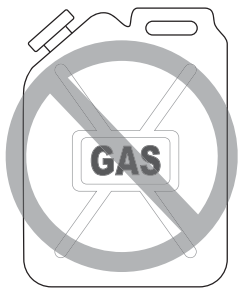
Hardware Recognition Chart

USE THIS CHART TO MATCH UP HARDWARE DURING THE ASSEMBLY PROCESS.



Clean Up

The unpainted surfaces are coated with a waxy oil to prevent corrosion during shipment. Remove this protective coating with a solvent cleaner or degreaser, such as shown in **Figure 12**. For thorough cleaning, some parts must be removed. **For optimum performance, clean all moving parts or sliding contact surfaces.** Avoid chlorine-based solvents, such as acetone or brake parts cleaner that may damage painted surfaces. Always follow the manufacturer's instructions when using any type of cleaning product.



⚠WARNING

Gasoline and petroleum products have low flash points and can explode or cause fire if used to clean machinery. DO NOT use these products to clean the machinery.

⚠CAUTION

Many cleaning solvents are toxic if inhaled. Minimize your risk by only using these products in a well ventilated area.

G2544—Solvent Cleaner & Degreaser
H9692—Orange Power Degreaser
Great products for removing shipping grease.

Figure 12. Cleaner/degreasers available from Grizzly.

Site Considerations

Floor Load

Refer to the **Machine Data Sheet** for the weight and footprint specifications of your machine. Some residential floors may require additional reinforcement to support both the machine and operator.

Placement Location

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your new machine. See **Figure 13** for the minimum working clearances.

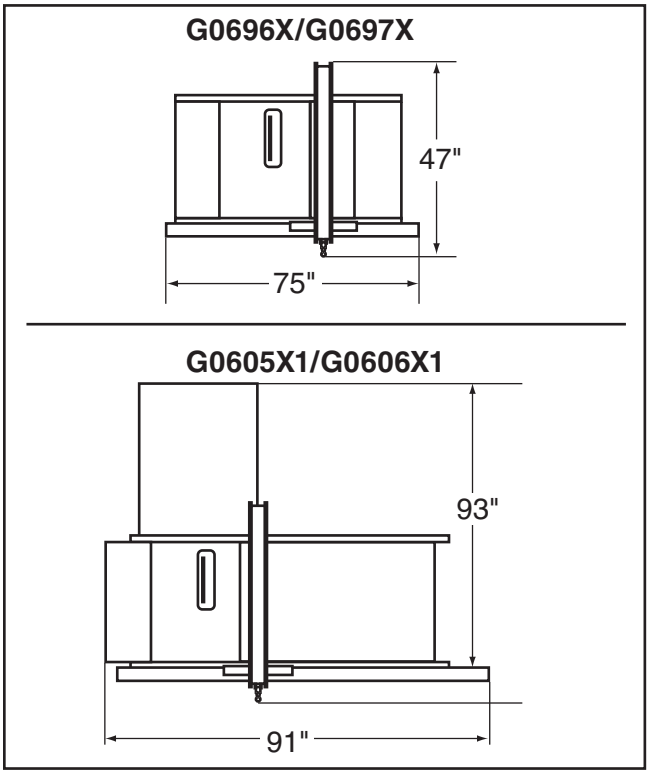
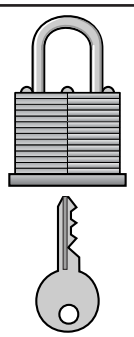


Figure 13. Minimum working clearances.



⚠CAUTION

Children and visitors may be seriously injured if unsupervised around this machine. Lock entrances to the shop or disable start switch or power connection to prevent unsupervised use.

Assembly

Assembly steps are the same for the Model G0605X1/G0606X1 and G0696X/G0697X except where noted. Assembly consists of installing the front and rear rails, attaching the extension wing (Model G0696X/G0697X) or extension table and outfeed table (Model G0605X1/G0606X1), then installing minor components.

To assemble the table saw:

1. Fasten the front rail onto the main table with (4) M8-1.25 x 25 flat head screws, as shown in **Figure 14**.

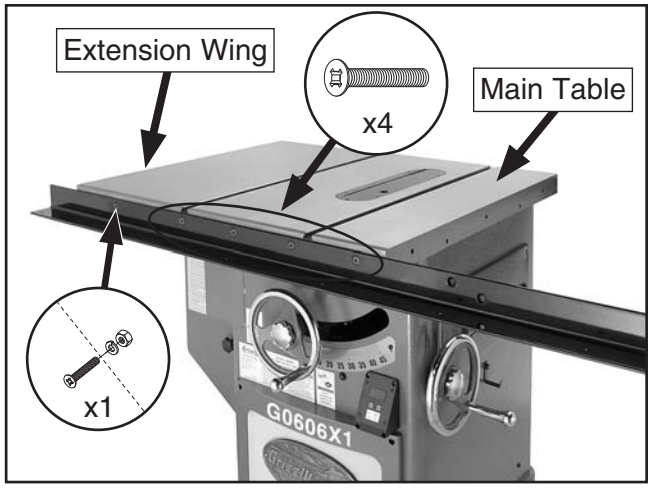


Figure 14. Front rail installed (Model G0605X1 shown).

2. Secure the left side of the front rail to the pre-installed extension wing with (1) M8-1.25 x 25 flat head screw, 8mm lock washer, and M8-1.25 hex nut (see **Figure 14**).

3. Fasten the rear rail to the table with (4) M8-1.25 x 25 cap screws, 8mm lock washers, and 8mm flat washers, as shown in **Figure 15**.

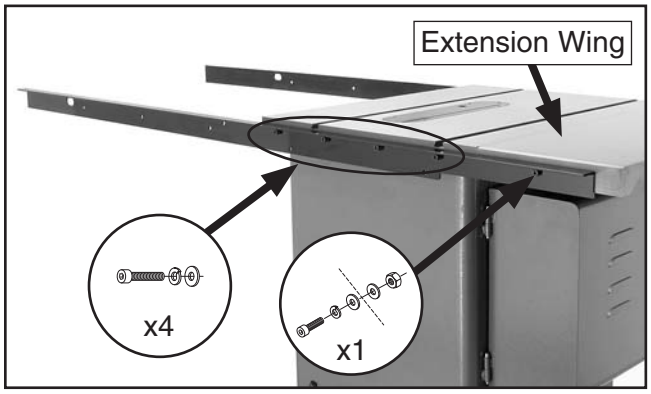


Figure 15. Rear rail installed (Model G0605X1 shown).

4. Fasten the right end of the rail to the pre-installed extension wing shown in **Figure 15** with (1) M8-1.25 x 25 cap screw, (2) 8mm lock washers, (1) 8mm flat washer and (1) M8-1.25 hex nut.

   —If you are assembling the G0696X or G0697X, continue to the ***G0696X/G0697X Extension Wing*** instructions below.

   —If you are assembling the G0605X1 or G0606X1, follow the instructions for installing the extension table (**Page 21**) and outfeed table (**Page 23**).

G0696X/G0697X Extension Wing

1. Inspect the extension wing and main table mating surfaces for burrs or foreign materials that may inhibit assembly.

   The mating edges of the wing and the table must be clean, smooth, and flat. Use a wire brush or file if necessary to clean up the edges. This step will ensure that the wing mounts properly to the main table.

2. With the assistance of a helper, place the extension wing between the rails, and fasten the wing to the front rail with (1) M8-1.25 flat head screw, 8mm lock washer and M8-1.25 hex nut (see **Figure 16**). Finger tighten for now.

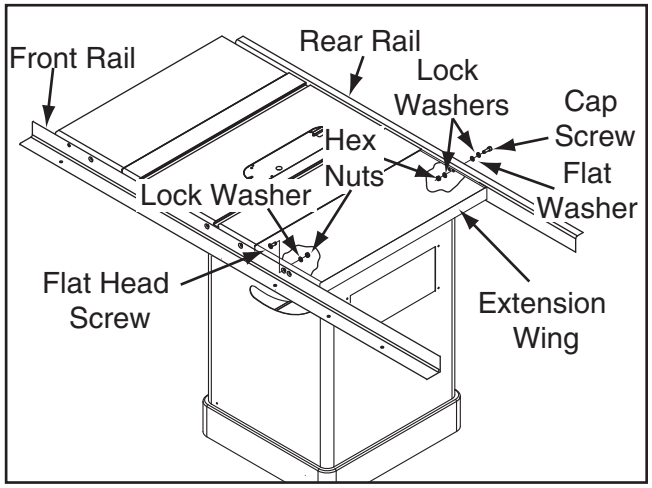


Figure 16. Extension wing attached to Model G0696X/G0697X.

3. Attach the extension wing to the rear rail with (1) M8-1.25 x 25 cap screw, (2) 8mm lock washers, (1) 8mm flat washer and (1) M8-1.25 hex nut, as shown in **Figure 16**. Finger tighten for now.

4. Attach the cast iron wing to the main table with (3) M10-1.5 x 35 hex bolts and 10mm lock washers, as shown in **Figure 17**. Finger tighten for now.

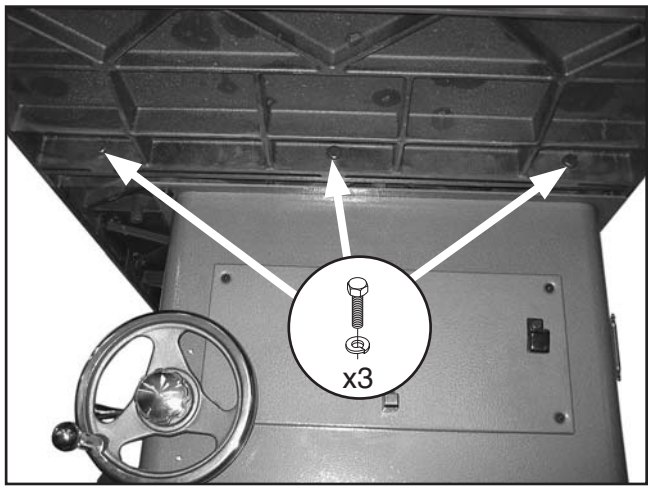


Figure 17. Extension wing installed.

5. Use a straightedge as a gauge and adjust the extension wing up/down until it is flush with the main table above each bolt, then completely tighten all the bolts.

6. Place the long straightedge across the extension wings and main table to make sure that the combined table surface is flat.

—If the combined table surface is flat, skip to the next step.

—If the outside end of the extension wing tilts down, use a strip of masking tape along the bottom edge of the main table to shim the extension wing up (**Figure 18**).

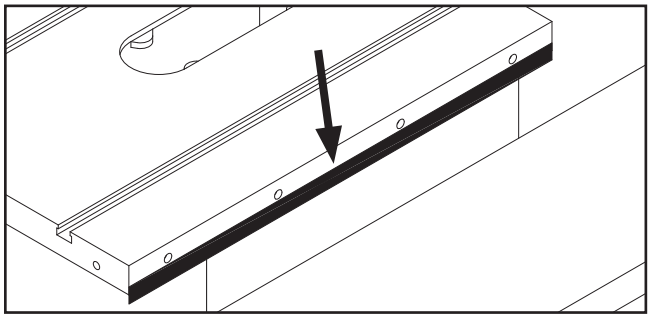


Figure 18. Masking tape location for tilting the extension wing up.

—If the outside end of the extension wing tilts up, use a strip of masking tape along the top edge of the main table to shim the extension wing down (**Figure 19**).

Note: *After re-installing wings, remove all excess masking tape with a razor blade.*

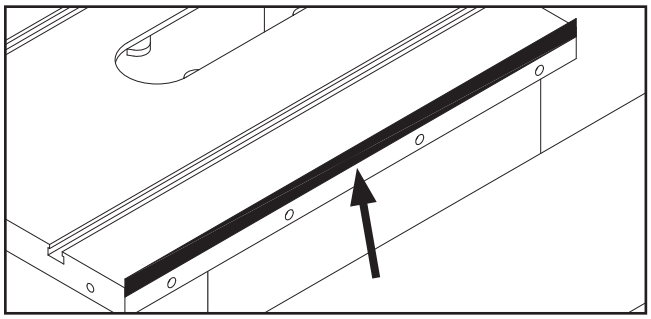


Figure 19. Masking tape location for adjusting the extension wing down.

7. Follow the ON/OFF Switch instructions on **Page 23**.

G0605X1/G0606X1 Extension Table

1. Thread (2) M10-1.5 x 25 hex bolts with 10mm flat washers onto the right side of the main table, as shown in **Figure 20**. Do not fully tighten the bolts.

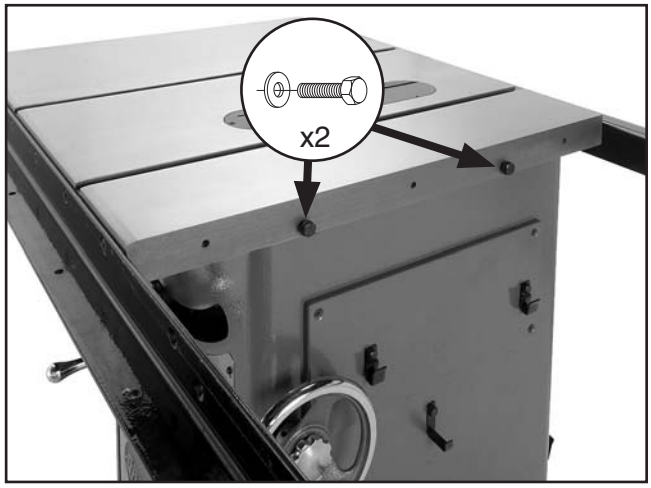


Figure 20. Hex bolts installed.

2. With the help of an assistant, place the extension table between the rails and slide the table slots over the bolts installed in **Step 1**.

3. While an assistant holds the extension table, fasten the front rail to the extension table with (3) M8-1.25 x 25 flat head screws, 8mm flat washers and M8-1.25 hex nuts (see **Figure 21**). Finger tighten the hex nuts for now.

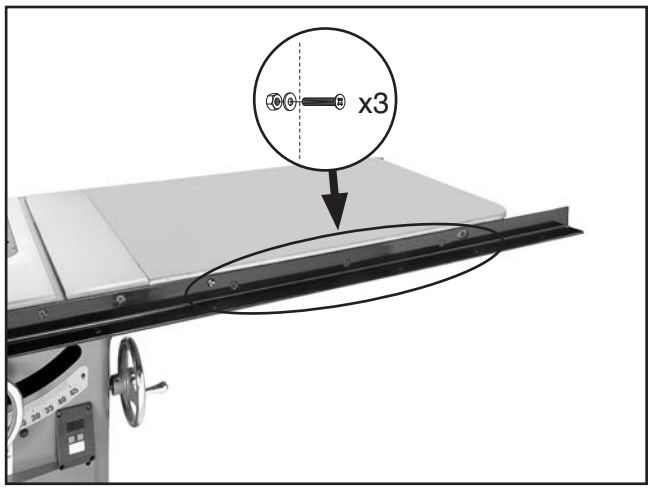


Figure 21. Front rail/table fastener locations.

4. Fasten the rear rail to the extension table with (3) M8-1.25 x 25 cap screws, (3) 8mm lock washers, (6) 8mm flat washers, and (3) M8-1.25 hex nuts, as shown in **Figure 22**. Finger tighten the hex nuts for now.

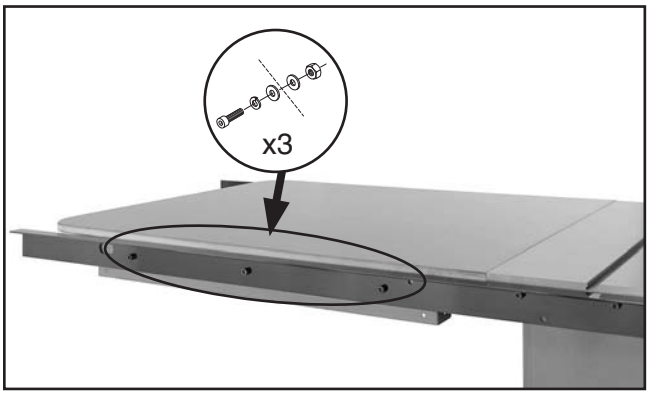


Figure 22. Rear rail/table fastener locations.

5. Align the main table and extension table with a straightedge (**Figure 23**), then tighten the fasteners shown in **Figure 21**.

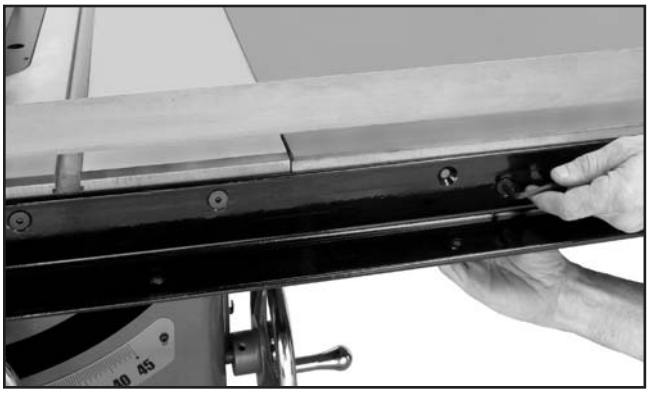


Figure 23. Aligning main extension table.

6. Repeat the aligning procedure and tighten the fasteners, as shown in **Figure 22**.

7. Tighten the hex bolts shown in **Figure 20**.

8. Thread a ⅜"-16 hex nut onto each foot, then-thread the feet into the bottom of the support legs, as shown in **Figure 24**.

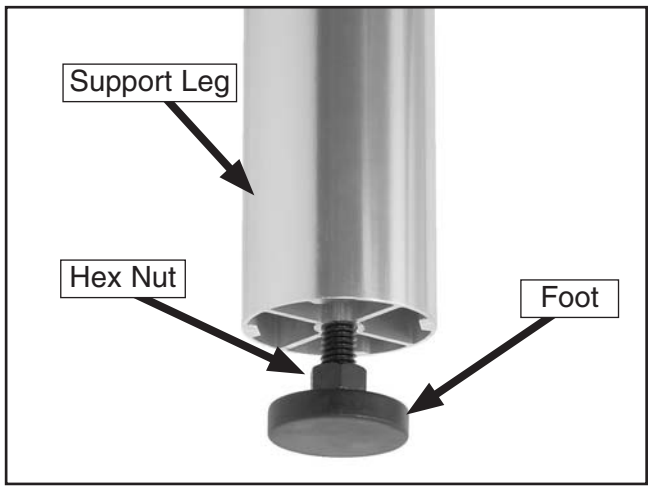


Figure 24. Foot installed on support leg.

9. Fasten the support legs to the main extension table with (8) M6-1 x 12 Phillips head screws and 6mm flat washers, as shown in **Figure 25**.

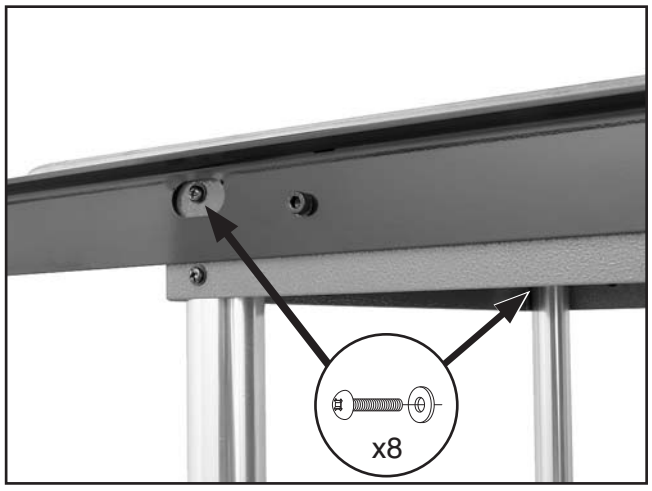


Figure 25. Support leg fastened to main extension table.

10. Rotate both feet until they touch the ground, and tighten the hex nuts against the legs to secure the feet.

11. Fasten the shelf end plate to the legs with (4) M6-1 x 12 Phillips head screws and 6mm flat washers, as shown in **Figure 26**.

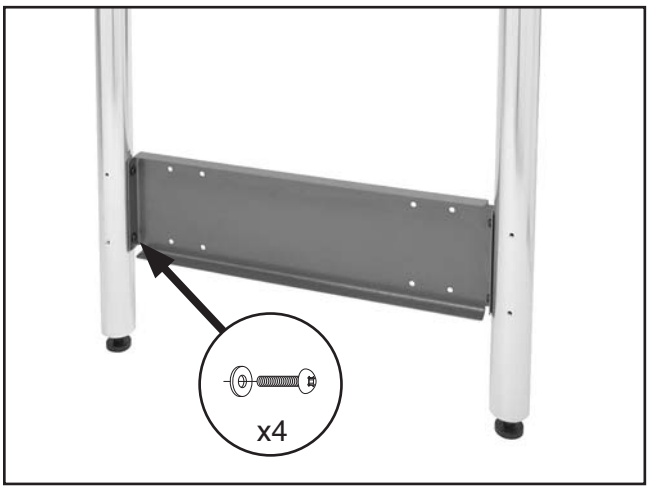


Figure 26. Installing shelf end plate on extension table legs.

12. Place the shelf brackets between the cabinet and support legs, and fasten with (4) M6-1 x 12 hex bolts, (4) 6mm flat washers and (2) M6-1 hex nuts, as shown in **Figure 27**.

Note: *The flange on the shelf bracket must point up to ensure proper installation.*

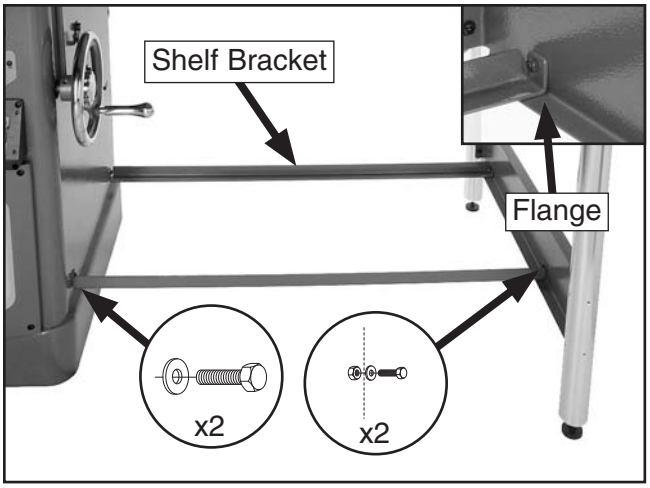


Figure 27. Shelf brackets installed.

13. Place the lower shelf on the brackets.

G0605X1/G0606X1 Outfeed Table

1. Turn the outfeed table upside down and place it on a level surface.

2. Install the feet, support legs, and shelf end plate in the same manner as described in **Extension Table** instructions on **Page 21**.

3. Place the extension table assembly upright with the feet on the ground, align the slots in the extension table bracket with the rear rail mounting holes, then fasten the table to the rail with (2) M8-1.25 x 16 flange bolts and M8-1.25 hex nuts, as shown in **Figure 28**.

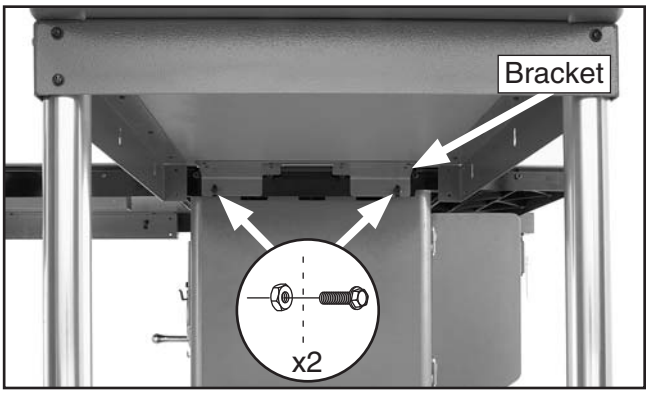


Figure 28. Outfeed table fastened to rear rail.

4. Secure the lower shelf brackets to the support legs and cabinet with (4) M6-1 x 12 hex bolts, (4) 6mm flat washers and (2) M6-1 hex nuts.

5. Install the lower shelf on the brackets.

6. Place the 91 3/8" fence tube over the 91 1/4" front rail and secure with (9) M8-1.25 x 12 flange bolts, as shown in **Figure 29.**

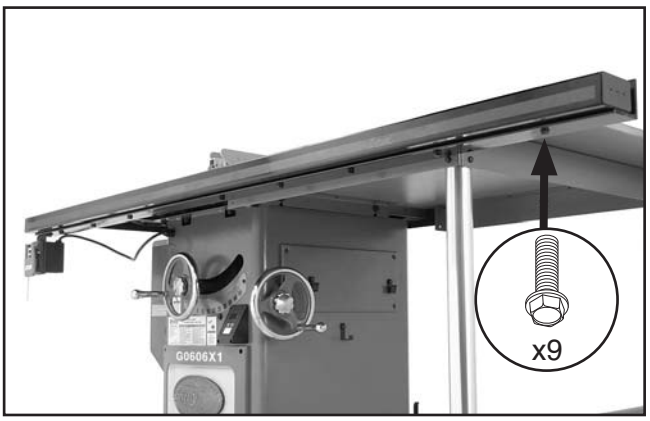


Figure 29. Fence tube mounted to front fence rail.

On/Off Switch

1. Fasten the switch to the left end of the front rail with (2) M8-1.25 x 12 flange bolts, and insert the anti-start safety pin, as shown in **Figure 30**, if it is not already installed.

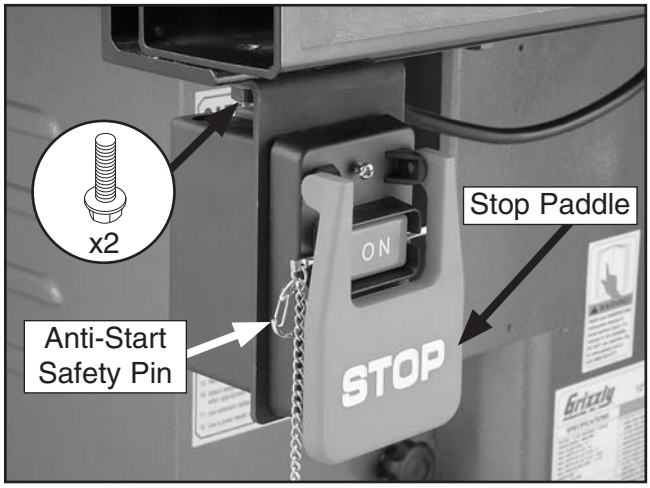


Figure 30. Switch installed.

Saw Blade and Arbor

1. Remove the table insert by unscrewing the flat head screw that fastens it to the table.

2. Raise the arbor all the way up and set the blade angle at 0°.

3. Put on a pair of heavy leather gloves and use an arbor wrench to loosen the hex bolt shown in **Figure 31**, to remove the riving knife, which is installed for shipping purposes. (For more info on installing/removing the riving knife refer to **Page 32**.)

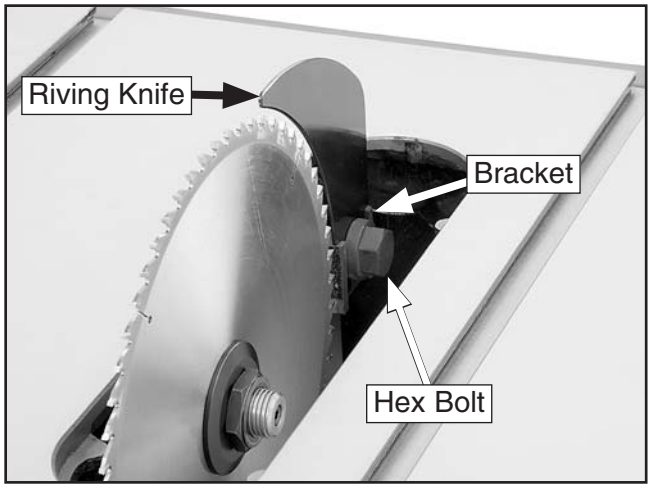


Figure 31. Riving knife installed.

4. At this point, you can leave the pre-installed 12" blade on the 1" arbor and proceed to **Step 9**, or if you desire to install a 5/8" arbor blade, follow **Steps 5-8**.

5. Remove the arbor nut, arbor flange, and existing blade.

6. Hold the arbor shaft with an arbor wrench and, using a 5mm hex wrench, remove the cap screw from the end of the arbor, as shown in **Figure 32**.

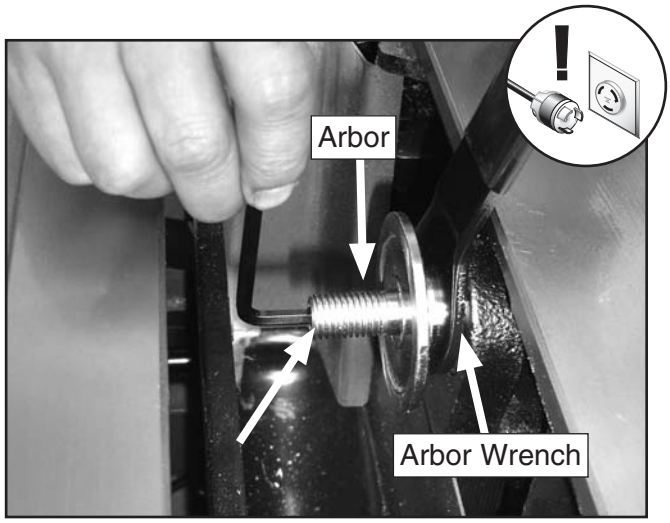


Figure 32. Removing arbor.

7. Slide the arbor out of the shaft.

8. Place a dab of grease or a thin coat of light machine oil onto the tapered part of the 5/8" arbor, install it into the shaft, then secure with the cap screw removed in **Step 6**.

   Note*: If the 1" arbor is hard to remove, thread the 1" arbor nut back onto the arbor without the blade, then tighten the nut to unseat the arbor.*

9. Install the 5/8" arbor blade, arbor flange, and arbor nut.

10. Use both arbor wrenches to make sure the blade arbor nut is tight (hold the arbor with one of the wrenches on the left side of the blade to keep it from moving), as shown in **Figure 33**.

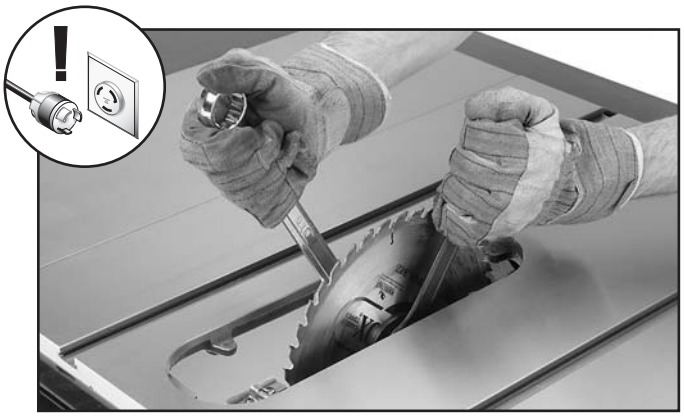


Figure 33. Example of securing blade.

Fence & Miter Gauge

1. Install the fence knob, as shown in **Figure 34**.

Figure 34. Fence knob installed.

2. Mount the fence on the front rail to the right of the blade.

3. Install the fence resting brackets (**Figure 35**) onto the back of the cabinet with the two M8-1.25 x 12 flange bolts.

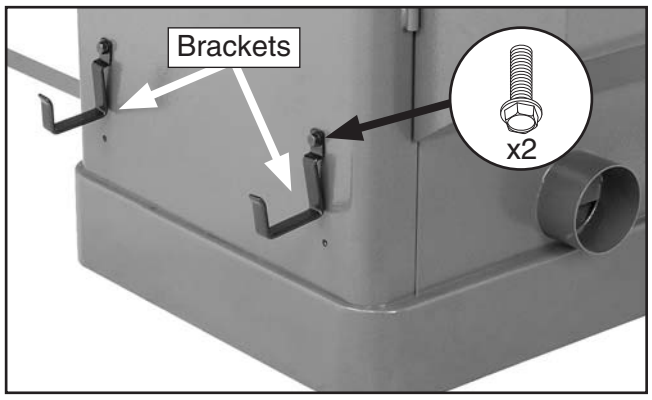


Figure 35. Fence resting brackets installed.

4. Install the miter gauge handle and 8mm flat washer onto the miter gauge, as shown in **Figure 36**.

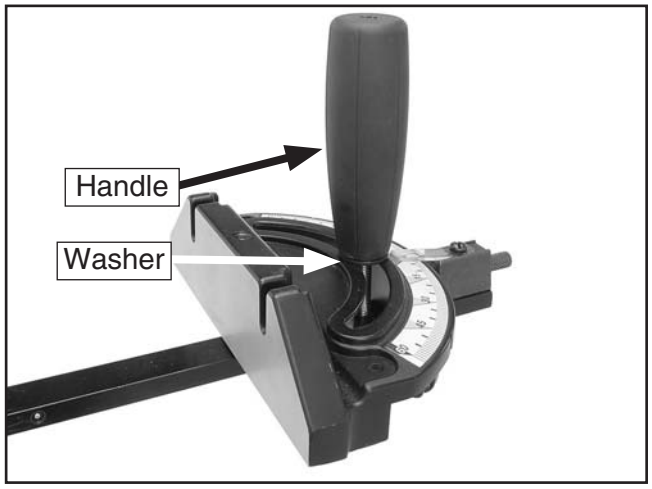


Figure 36. Miter gauge installed.

5. Slide the miter gauge into the T-slot on the left side of the blade; or store it temporarily on the brackets near the blade angle handwheel.

⚠CAUTION

To reduce the risk of kickback when cross-cutting a workpiece with the miter gauge, remove the fence or move it aside. Do not use the miter gauge and fence at the same time.

Checking Fence Parallelism

The blade was set parallel with the miter slot at the factory, which affects whether the fence is parallel when mounted to the table. We recommend verifying that this setting did not change during shipping.

To verify fence parallelism:

1. Slide the fence along the rail.

   —If the fence drags across the table, then loosen the hex nut on the foot at the rear of the fence and adjust the foot to raise the fence off of the table—just enough so the gap between the fence and the table is even from front to back. Then tighten the hex nut on the foot.

2. Slide the fence up against the right hand edge of the miter slot, and lock it in place. Examine how the fence lines up with the miter slot and the blade, as shown in **Figure 37**.

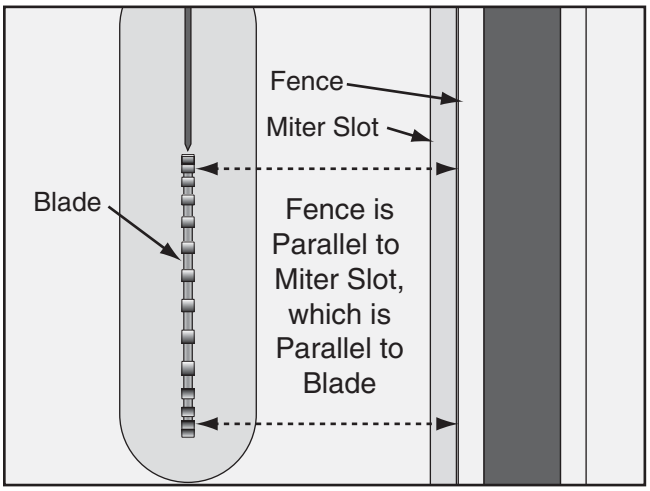


Figure 37. Checking fence parallelism with blade.

Note: *It's permissible for the back of the fence to pivot outward 1/64" from being parallel with the blade. This creates a slightly larger opening between the fence and the blade, at the rear of the blade, to reduce the risk of workpiece binding or burning as it is fed through the cut.*

*Many woodworkers intentionally set up their fence in this manner. Keep this in mind before adjusting your fence. For more details see **Figure 104** on **Page 60**.*

—If the fence/miter slot are parallel with the blade, as shown in **Figure 37**, proceed to **Blade Guard**.

—If the fence is not parallel with the blade/miter slot, then you MUST adjust the fence, as described in **Fence Adjustments** on **Page 58**, so that it is parallel with the blade.

—If the miter slot is not parallel with the blade, you must follow the procedures described in **Miter Slot to Blade Parallelism** on **Page 55**.

Blade Guard & Splitter

To install the blade guard and splitter:

1. Using an arbor wrench, loosen the hex bolt shown in **Figure 31** on **Page 23,** if you have not already done so.

2. Insert the splitter into the bracket slot and tighten the hex bolt (refer to **Figure 31**) to lock the splitter.

3. Lift the blade guard cover just enough to slide the table insert into the table slot over the blade (see **Figure 38**).

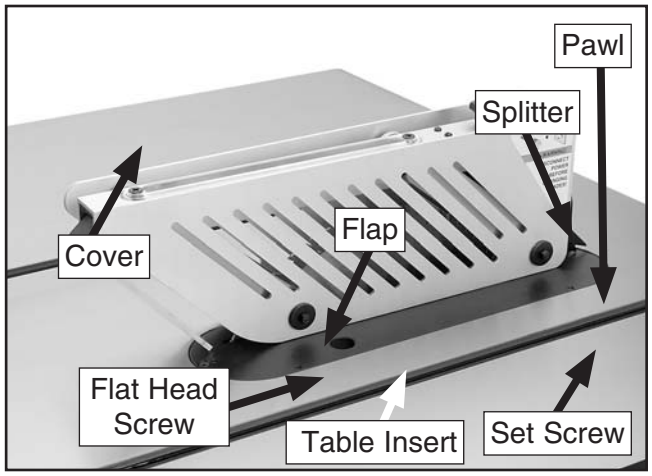


Figure 38. Blade guard installed.

Note: *Make sure the clear plastic flap is pushed toward the inside of the guard.*

4. Adjust the table insert set screws to make sure the insert is flush with the table (use a straightedge as a guide), then tighten the flat head screw to secure the table insert in place.

Note: *Do not over-tighten the flat head screw or it may lift the table insert.*

5. Swing one side of the blade guard up and out of the way.

6. While lifting up on the right splitter pawl, place a straightedge against the blade and the splitter. When properly aligned, the splitter/riving knife will be in the "Alignment Zone," shown in **Figure 39**, and will be parallel with the blade.

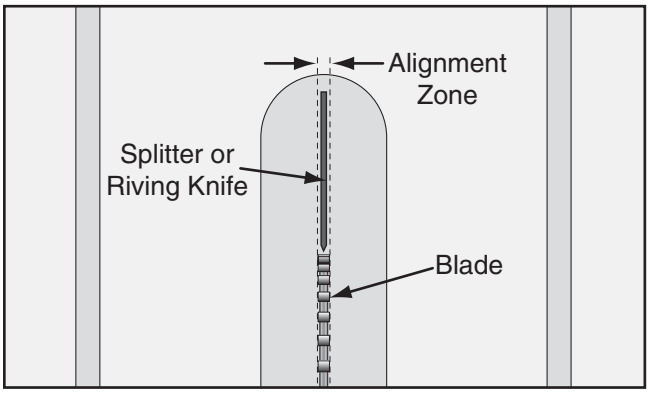


Figure 39. Splitter/riving knife alignment zone.

—If the splitter/riving knife is not inside the alignment zone, then it needs to be shimmed with the included metal shims. Proceed to **Shimming Splitter/Riving Knife** instructions on **Page 57**.

—If the splitter/riving knife is not parallel with the blade, then it needs to be straightened. Carefully bend the splitter into alignment by hand.

7. Return the right pawl and blade guard cover to their down positions.

Dust Collection

⚠CAUTION

DO NOT operate the Model G0605X1/G0606X1/G0696X/G0697X without an adequate dust collection system. This saw creates substantial amounts of wood dust while operating. Failure to use a dust collection system can result in short and long-term respiratory illness.

Components and Hardware Needed: Qty
Dust Hose 4" (not included) 1
Hose Clamps 4" (not included) 2
Dust Collection System (not included) 1

Recommended CFM at Dust Port: 400 CFM
Do not confuse this CFM recommendation with the rating of the dust collector. To determine the CFM at the dust port, you must consider these variables: (1) CFM rating of the dust collector, (2) hose type and length between the dust collector and the machine, (3) number of branches or wyes, and (4) amount of other open lines throughout the system. Explaining how to calculate these variables is beyond the scope of this manual. Consult an expert or purchase a good dust collection "how-to" book.

To connect a dust collection hose:

1. Fit a 4" dust hose over the dust port, as shown in **Figure 40**, and tightly secure in place with a hose clamp.

2. Tug the hose to make sure it does not come off. **Note:** *A tight fit is necessary for proper performance.*

Figure 40. Dust hose attached to dust port.

Test Run

Once the assembly is complete, test run your machine to make sure it runs properly and is ready for regular operation.

The test run consists of verifying the following: 1) The motor powers up and runs correctly, and 2) the safety disabling mechanism on the switch works correctly, 3) the blade turns the correct direction (the machine is not wired out of phase—G0606X/G0697X only).

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using the machine immediately, then review **Troubleshooting** on **Page 51**.

If you still cannot remedy a problem, contact our Tech Support at (570) 546-9663 for assistance.

To test run the machine:

1. Make sure you have read the safety instructions at the beginning of the manual and that the machine is setup properly.

2. Make sure all tools and objects used during setup are cleared away from the machine.

3. Connect the machine to the power source, and remove the switch safety pin.

4. Verify that the machine is operating correctly by turning it ***ON***.

   —When operating correctly, the machine runs smoothly with little or no vibration or rubbing noises.

   —Investigate and correct strange or unusual noises or vibrations before operating the machine further. Always disconnect the machine from power when investigating or correcting potential problems.

5. Turn the machine ***OFF***.

6. Insert the switch disabling pin through the green ON button, as shown in **Figure 41**.

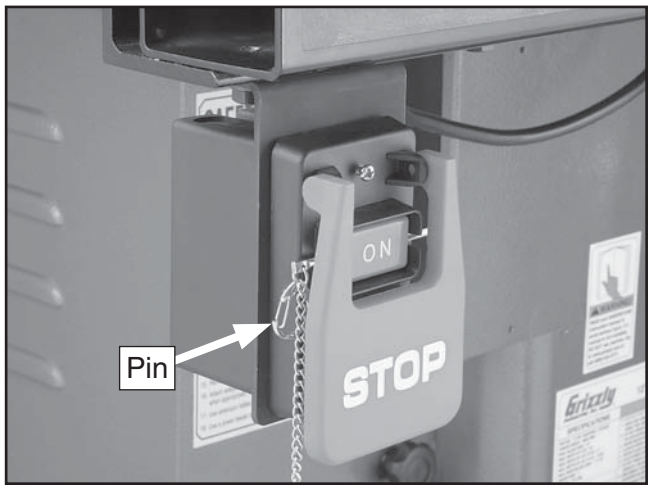


Figure 41. Switch disabling pin inserted into ON button.

7. Press the green ON button to test the disabling feature on the switch.

   —If the machine does not start, the switch disabling feature is working as designed.

   —If the machine starts, immediately stop the machine. The switch disabling feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

8. **Model G0606X1/G0697X Only:** Verify that the power is not connected out of phase by starting/stopping the table saw and determining if the motor turns in the correct direction, using the criteria below:

   —If the blade turns clockwise (standing at the left front side of the table saw), it is turning in the correct direction. Go to **Step 9**.

   —If the blade turns counterclockwise and toward the back of the saw (standing at the left front side of the table saw), it is turning in the wrong direction.

   Stop the table saw, shut ***OFF*** the power source, swap any two of the three incoming power wires—L1, L2, or L3—that connect to the saw (see **Figure 42**). If using a phase converter for 220V 3-phase operation, ONLY swap L1 and L3.

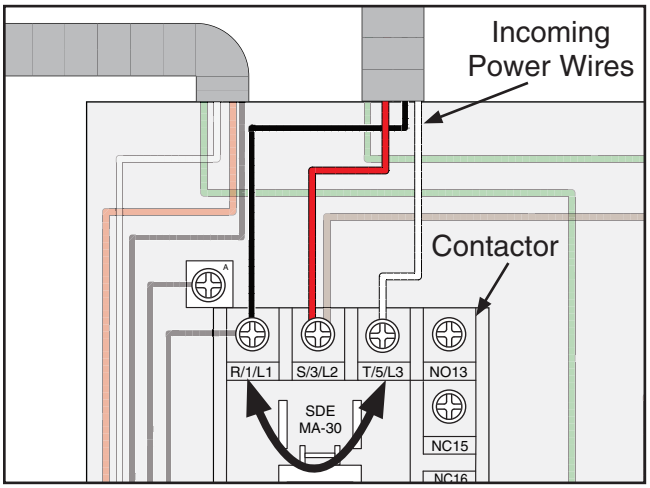


Figure 42. Example of switching incoming power wires.

9. The saw is now ready to operate.

Recommended Adjustments

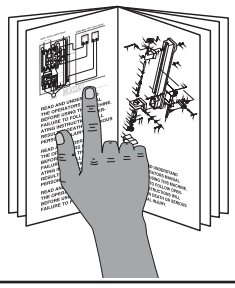
For your convenience, the adjustments listed below have been performed at the factory and no further setup is required to operate your machine. However, because of the many variables involved with shipping, we recommend that you at least verify the following adjustments to ensure that the cutting you do with your new machine is safe and accurate.

Step-by-step instructions for these adjustments can be found in **SECTION 7: SERVICE**.

Adjustments that should be verified:

1. Blade Tilt Stop Accuracy (**Page 53**).
2. Miter Slot Parallel to Blade (**Page 55**).
3. Splitter/Riving Knife Alignment (**Page 57**).

SECTION 4: OPERATIONS

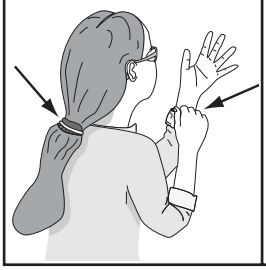


⚠WARNING

To reduce the risk of serious injury when using this machine, read and understand this entire manual before beginning any operations.

⚠WARNING

Damage to your eyes, lungs, and ears could result from using this machine without proper protective gear. Always wear safety glasses, a respirator, and hearing protection when operating this machine.



⚠WARNING

Loose hair, clothing, or jewelry could get caught in machinery and cause serious personal injury. Keep these items away from moving parts at all times to reduce this risk.

NOTICE

If you have never used this type of machine or equipment before, WE STRONGLY RECOMMEND that you read books, trade magazines, or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

Basic Controls

ON/OFF Switch: Starts and stops the motor.

Safety Pin & Chain: This feature disables the switch to prevent accidental startup.

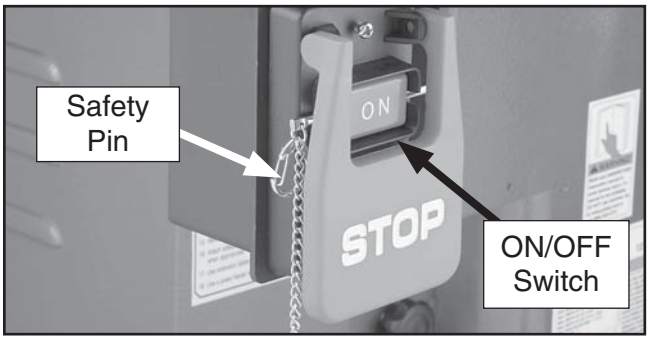


Figure 43. Disabling switch.

Blade Height Lock: Locks the blade height.

Blade Height Handwheel: Adjusts blade height.

Digital Readout: Displays blade tilt. **Note:** *The readout must be recalibrated (see **Page 62**) if the power is disconnected.*

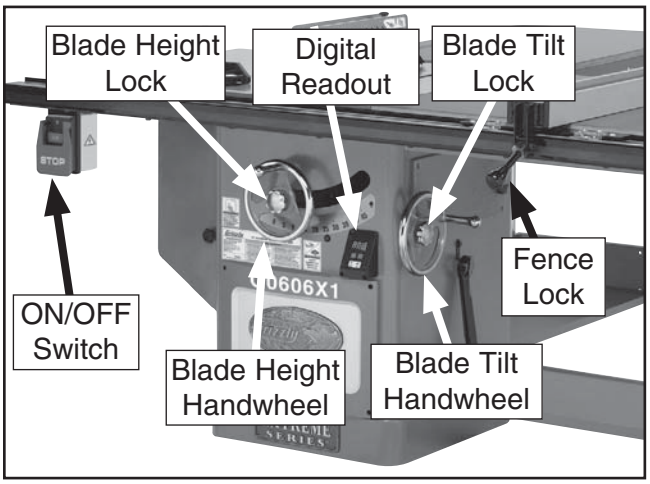


Figure 44. Basic table saw controls.

Blade Tilt Lock: Locks blade tilt angle.

Blade Tilt Handwheel: Adjusts the blade angle.

Fence Lock: Locks and unlocks fence position.

Operation Overview

Setting up for a typical operation consists of the following steps:

1. Make sure the blade tilt is correct. If it needs to be adjusted, use the blade tilt handwheel, and always tighten the blade tilt lock after adjustments have been made.

2. Set the blade height approximately ¼" higher than the workpiece thickness by turning the blade height handwheel, then lock the blade height in place by tightening the height lock.

3. Adjust the fence to the desired width of cut, then lock it in place by firmly pushing the fence lock down until it stops.

Operation Tips

The tips below are intended to supplement **SECTION 1: SAFETY**. But remember, no safety list can cover every situation. The operator is ultimately responsible for their own safety, as well as the safety of bystanders. Every cutting operation is different and may require safety equipment or safety procedures not mentioned in this manual.

Follow these tips EVERY time you use your saw:

- Stand to the left of the blade line-of-cut when performing a cutting operation.
- Turn ***OFF*** the saw and allow the blade to come to a complete stop before removing cut-off pieces.
- Make sure the riving knife is always aligned with the main blade before cutting!
- Always position the blade ¼" above the workpiece thickness.
- Carefully plan each cutting operation to avoid injuries.
- Plan your cut to avoid putting your hands near the blade or reaching across the blade.

Non-Through & Through Cuts

Non-Through Cuts

A non-through cut is a sawing operation where the blade does not protrude above the top face of the wood stock, as shown in **Figure 45**.

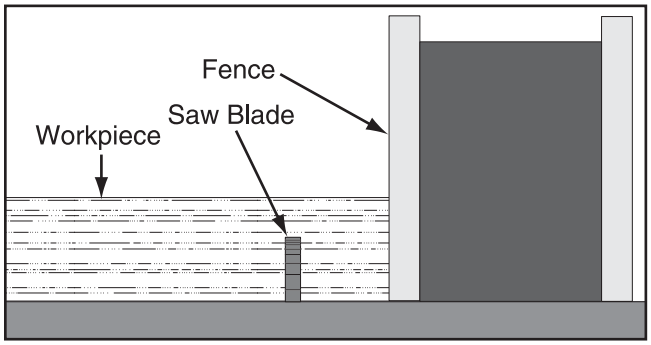


Figure 45. Example of a non-through cut.

Examples of non-through cuts include dadoes and rabbets. Non-through cuts have a higher risk of injury from kickback because the splitter and blade guard must be removed. When making non-through cuts with a standard blade, the riving knife MUST be installed. When making non-through cuts with a dado blade, extreme care, including using multiple light passes must be used, because neither the blade guard or riving knife can be used.

Through Cuts

A through cut is a sawing operation in which the workpiece is completely sawn through, as shown in **Figure 46**. Examples of through cuts are rip cuts, cross cuts, miter cuts, and beveled cuts. The blade guard assembly MUST be used when performing through cuts.

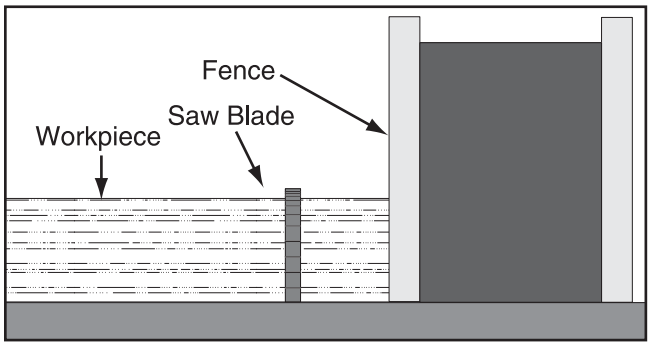


Figure 46. Example of a through cut (blade guard not shown for illustrative clarity).

Blade Guard Assembly

The term "blade guard" refers to the assembly that consists of the metal covers, the splitter, and the anti-kickback pawls on each side of the splitter (**Figure 47**). Each of these components have important safety functions during the operation of the saw.

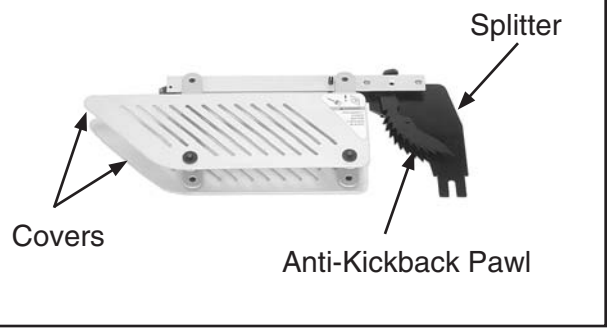


Figure 47. Blade guard assembly components.

Guard

The metal guard is designed to lift as the workpiece is pushed into the blade and remain in contact with the workpiece throughout the entire cut.

The guard reduces injury risk by providing a barrier around the blade that prevents accidental contact and contains flying wood chips.

To ensure the that the guard does its job effectively, the guard must always be in the downward position while cutting, and the hinge mechanism must be maintained in good working condition so the guard can freely pivot up and down.

Splitter

The splitter is a metal plate that prevents the newly cut kerf of the workpiece from pinching the backside of the blade, causing kickback.

The splitter also acts as a barrier behind the blade to prevent hands from being pulled into the blade if a kickback occurs.

⚠WARNING

In order to work properly, the splitter cannot be bent or misaligned with the blade. If the splitter gets accidentally bent, take the time to straighten it or just replace it. Using a bent or misaligned splitter will increase the risk of kickback!

NOTICE

Some thin-kerf blades may be thinner than the thickness of the splitter. DO NOT install these blades on the saw, because the workpiece will hit the splitter during operation, possibly causing kickback. Always make sure the kerf of a blade you install is not thinner than the splitter.

Anti-Kickback Pawls

The anti-kickback pawls allow the workpiece to travel in only one direction. If the workpiece moves backwards, such as during a kickback, the pawls will dig into the workpiece to slow or stop it.

To work properly, the pawls must return to their bottom-most position after pivoting. If they fail to do this, the pivot spring may have been dislodged or broken and will need to be fixed/replaced.

When to Use the Blade Guard

The blade guard assembly MUST always be installed on the saw for all normal through cuts (those where the blade cuts all the way through the thickness of the workpiece).

When Not to Use the Blade Guard

The blade guard cannot be used on any non-through cuts (those in which the blade does not cut all the way through the thickness of the workpiece).

Sometimes the blade guard or its components can get in the way when cutting very narrow workpieces or other specialized cuts. Because the blade guard is provided to decrease your risk of injury, it should not be used if it gets in the way of making a safe cut. Use good judgement!

IMPORTANT: Whenever the blade guard cannot be used, the riving knife must be installed.

Riving Knife

The riving knife (**Figure 48**) works in the same manner as the blade splitter on the blade guard assembly. It is a metal plate that prevents the newly cut workpiece from pinching the backside of the blade and causing kickback.

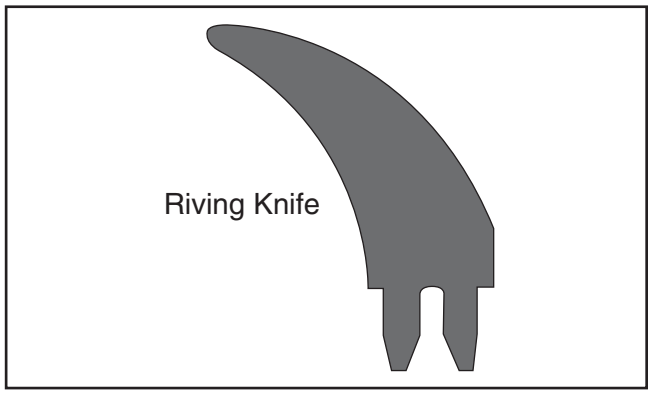


Figure 48. Illustration of a typical riving knife.

The key difference between the blade splitter and the riving knife is that the riving knife mounts below the blade's highest point of rotation, as shown in **Figure 49**.

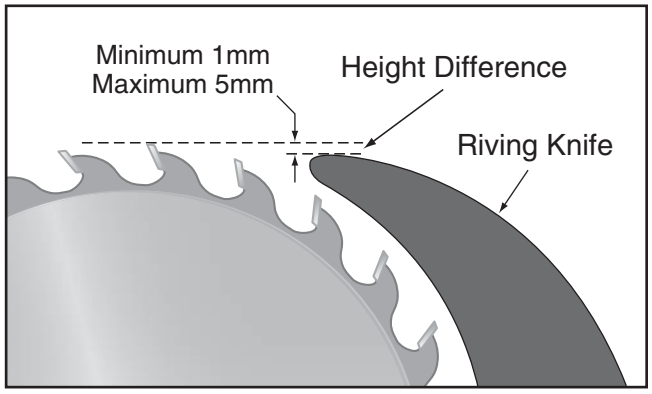


Figure 49. Height difference between riving knife and blade.

The height difference between the riving knife and the blade allows the workpiece to pass over the blade during non-through cuts (those in which the blade does not cut all the way through the thickness of the workpiece).

The riving knife also acts as a barrier behind the blade to reduce the risk of hands being pulled into the blade if a kickback occurs.

⚠WARNING

In order to work properly, the riving knife cannot be bent or misaligned with the blade. If the riving knife gets accidentally bent, take the time to straighten it or just replace it. Using a bent or misaligned riving knife will increase the risk of kickback!

NOTICE

Some thin-kerf blades may be thinner than the thickness of the riving knife. DO NOT install these blades on the saw, because the workpiece will hit the riving knife during operation, possibly causing kickback. Always make sure the kerf of a blade you install is not thinner than the riving knife.

When to Use the Riving Knife

Use the riving knife for all non-through cuts made with a standard table saw blade (i.e., dadoes or rabbet cuts in which a dado blade is NOT used, and when using a tenoning jig).

Also, use the riving knife for those special operations where the blade guard or its components get in the way of safe operation, such as with very narrow cuts.

When Not to Use the Riving Knife

The riving knife CANNOT be used with a dado blade. Otherwise, the riving knife height will exceed the blade height and the workpiece will hit the riving knife during the cut, forcing the operator into a dangerous situation of trying to turn the saw off with the workpiece stuck halfway through the cut.

In addition, although it is possible to use the riving knife for through cutting operations, the blade guard assembly offers far more injury protection and risk reduction than the riving knife. Therefore, **we strongly recommend** that you use the blade guard assembly instead of the riving knife for through cuts.

Blade Selection

Ripping blade features:
- Best for cutting with the grain of the workpiece.
- 20-40 teeth.
- Flat-top ground tooth profile.
- Large gullets for large chip removal.

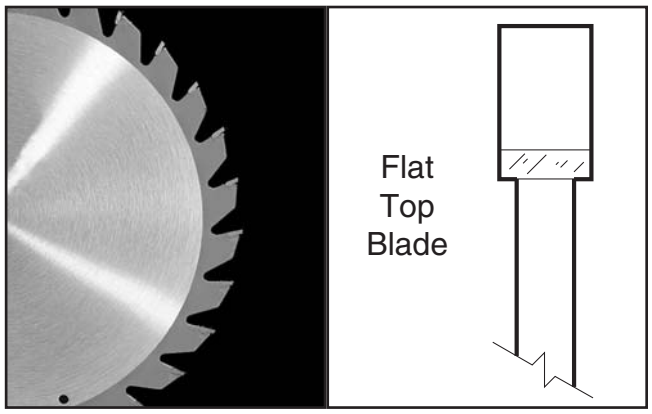


Figure 50. Ripping blade.

Crosscut blade features:
- Best for cutting across the grain of the workpiece.
- 60-80 teeth.
- Alternate top bevel tooth profile.
- Small hook angle and a shallow gullet.

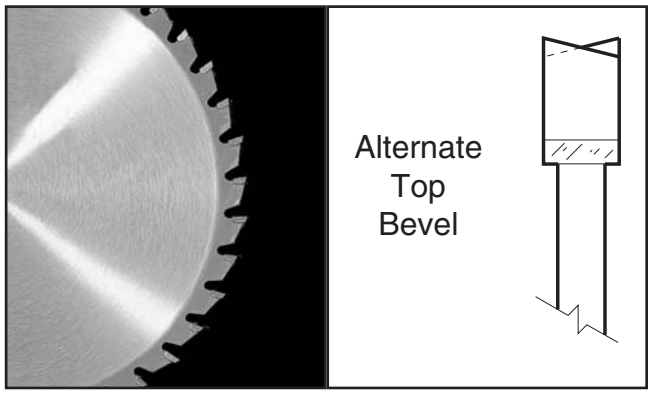


Figure 51. Crosscutting blade.

Combination blade features:
- Adequate for cutting both with and across the grain.
- 40-50 teeth.
- Alternate top bevel and flat, or alternate top bevel and raker tooth profile.
- Teeth are arranged in groups of five.
- Gullets are small and shallow within the groups of five teeth, similar to a cross-cut blade; then large and deep between each group of five, like a ripping blade.

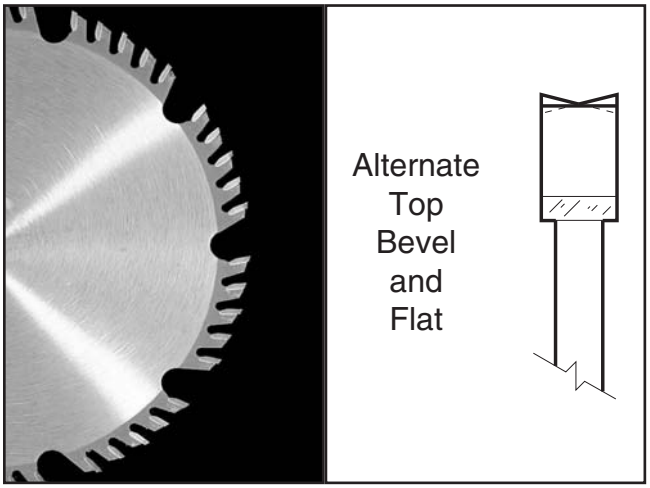


Figure 52. Combination blade.

Laminate blade features:
- Best for cutting plywood or veneer.
- 40-80 teeth.
- Triple chip tooth profile.
- Very shallow gullet.

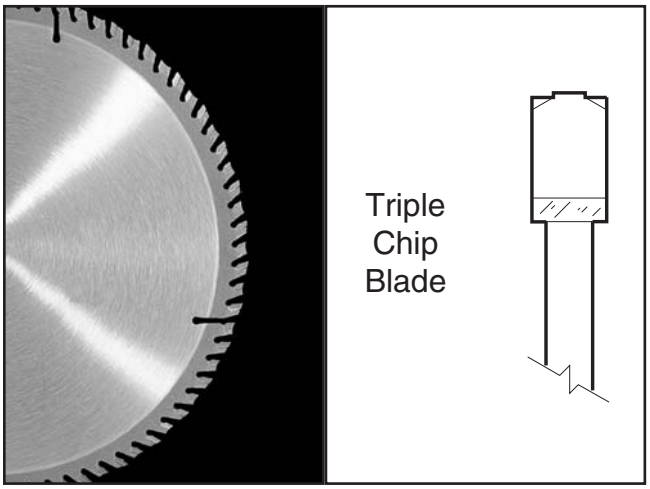


Figure 53. Laminate blade.

Dado Blades:
There are two types of dado blades: stacked and wobble.

- **Stacked Dado Blade**: These dedicated dado cutting blade sets consist of up to 8 individual blades. Multiple cutters are "stacked" between two outside blades. The width of the dado is determined by the combination of cutters that are “stacked” together. The dado is cut in a single pass, leaving a smooth and square channel in the face of the workpiece. Stacked dado blades are the most expensive option, but are worth considering if your projects require a lot of visible dado cuts. A stacked dado blade is shown in **Figure 54**.

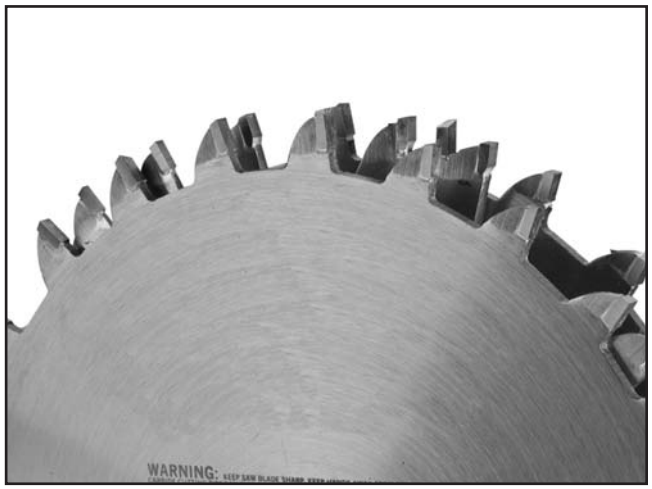


Figure 54. Stacked dado blade.

- **Wobble Dado Blade**: Also a dedicated dado blade, a wobble blade usually consists of a single blade that is tilted on the arbor shaft while it is spinning. The channel is cut in the face of the workpiece as the blade passes through its pre-adjusted width of travel. Wobble blades are an inexpensive option when visibly pleasing channels are not a concern.

Thin Kerf Blade:
A blade with a kerf or thickness that is thinner than a standard blade. Since thin kerf blades are typically the same thickness of the splitter or riving knife—and in some cases thinner—we DO NOT recommend that they be used on this saw due to the increased risk of kickback.

Blade Installation

⚠CAUTION
The saw blade is sharp. Use extra care or wear gloves when handling the blade or working near it.

Use this procedure when changing or installing blades.

To install a new blade:

1. DISCONNECT THE SAW FROM POWER!

2. Put on heavy leather gloves and raise the arbor all the way up.

3. Remove the table insert and blade guard/riving knife, depending on what is installed.

4. Use the arbor wrenches to loosen and remove the arbor nut, flange, and blade. **Note:** *The arbor nut (see **Page 13**) has right hand threads; turn it counterclockwise to loosen.*

5. Slide the blade over the arbor with the teeth facing the front of the saw, as shown in **Figure 55**.

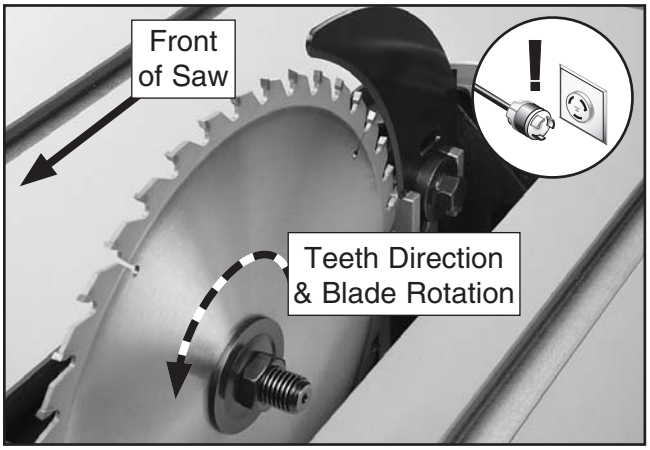


Figure 55. Example of correct blade direction.

6. Re-install the arbor flange and the arbor nut, and tighten them against the blade with the wrenches included with the saw. DO NOT overtighten.

7. Reinstall the blade guard/riving knife and the table insert.

Stock Inspection & Requirements

Some workpieces are not safe to cut or may require modification before they are safe to cut. **Before cutting, inspect all workpieces for the following:**

- ***Material Type:*** This machine is intended for cutting natural and man-made wood products, laminate covered wood products, and some plastics. Cutting drywall or cementitious backer board creates extremely fine dust and may reduce the life of the motor bearings. This machine is NOT designed to cut metal, glass, stone, tile, etc.; cutting these materials with a table saw may lead to injury.

- ***Foreign Objects:*** Nails, staples, dirt, rocks and other foreign objects are often embedded in wood. While cutting, these objects can become dislodged and hit the operator, cause kickback, or break the blade, which might then fly apart. Always visually inspect your workpiece for these items. If they can't be removed, DO NOT cut the workpiece.

- ***Large/Loose Knots:*** Loose knots can become dislodged during the cutting operation. Large knots can cause kickback and machine damage. Choose workpieces that do not have large/loose knots or plan ahead to avoid cutting through them.

- ***Wet or "Green" Stock:*** Cutting wood with a moisture content over 20% causes unnecessary wear on the blades, increases the risk of kickback, and yields poor results.

- ***Excessive Warping:*** Workpieces with excessive cupping, bowing, or twisting are dangerous to cut because they are unstable and often unpredictable when being cut. DO NOT use workpieces with these characteristics!

- ***Minor Warping:*** Workpieces with slight cupping can be safely supported if the cupped side is facing the table or the fence. On the contrary, a workpiece supported on the bowed side will rock during a cut and could cause kickback or severe injury.

Ripping

"Ripping" means cutting with the grain of a natural wood workpiece. In other man-made materials such as MDF or plywood, ripping simply means cutting lengthwise.

⚠WARNING

Serious injury can be caused by kickback. Kickback is a high-speed expulsion of stock from the table saw toward an operator. The operator or bystanders may be struck by flying stock, or the operator's hands can be pulled into the blade during kickback.

To make a rip cut:

1. Review **Preventing Kickback** on **Page 8** and take the necessary precautions to prevent kickback.
2. If using natural wood, joint one long edge of the workpiece on a jointer.
3. DISCONNECT THE SAW FROM POWER!
4. Ensure that the blade guard/splitter is installed.
5. Set the fence to the desired width of cut on the scale.
6. Adjust the blade height so the highest saw tooth protrudes approximately ¼" above the workpiece.
7. Set up safety devices such as featherboards or other anti-kickback devices.
8. Rotate the blade by hand to make sure it does not come into contact with any of the safety devices.
9. Connect the saw to the power source, turn it ***ON,*** and allow it to reach full speed.

Note: *The jointed edge of the workpiece must slide against the fence during the cutting operation.*

10. Use a push stick to feed the workpiece through the saw blade, as shown in **Figure 56**, until the workpiece is completely past the saw blade.

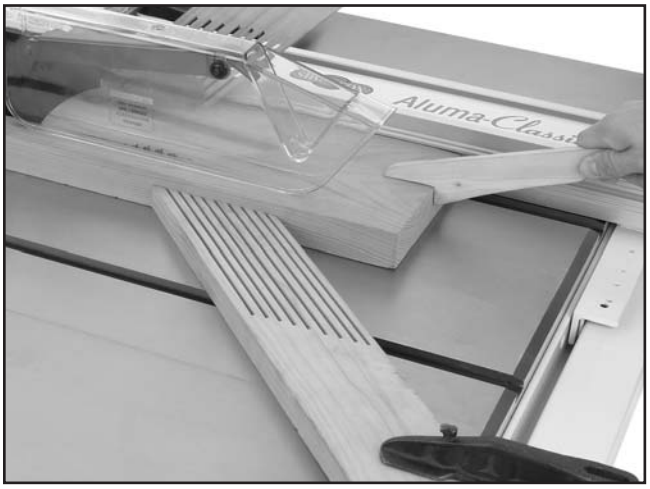
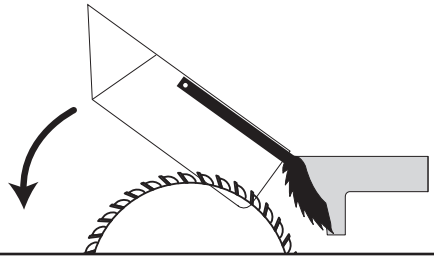


Figure 56. Typical ripping operation.

⚠WARNING

Turn *OFF* the saw and allow the blade to come to a complete stop before removing the cut-off piece. Failure to follow this warning could result in serious personal injury.

⚠WARNING



Keep the blade guard installed and in the down position. Failure to do this could result in serious personal injury or death.

Crosscutting

"Crosscutting" means cutting across the grain of a natural wood workpiece. In other man-made materials, such as MDF or plywood, crosscutting means cutting across the width of the workpiece.

To make a crosscut using the miter gauge:

1. DISCONNECT THE SAW FROM POWER!
2. Ensure that the blade guard/splitter is installed.
3. Move the rip fence aside and position the miter gauge, adjusted to 90°, in a miter slot.
4. Adjust the blade height so the teeth protrude approximately ¼" above the workpiece.
5. Slide the miter gauge near the blade and adjust the workpiece so the blade will cut on the waste side of the line.
6. Plug in the table saw, turn it ***ON,*** and allow it to reach full speed.
7. Hold the workpiece firmly against the face of the miter gauge (**Figure 57**), and ease it through the blade until the workpiece is completely past the saw blade.

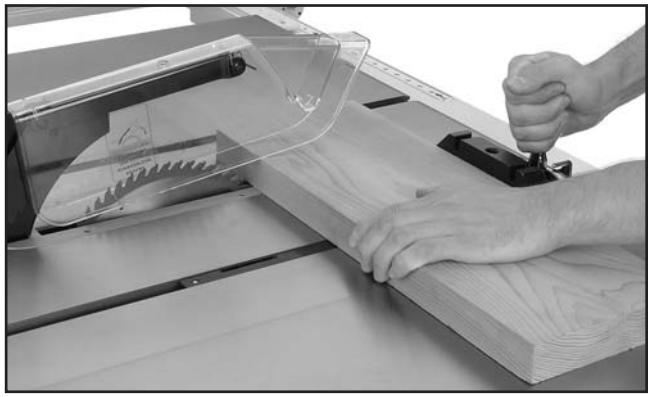


Figure 57. Typical crosscutting operation.

⚠WARNING

Turn *OFF* the saw and allow the blade to come to a complete stop before removing the cut-off piece. Failure to follow this warning could result in serious personal injury

Miter Cuts

A miter is an angled crosscut. Miters are usually cut in the same manner as crosscuts, using the miter gauge and a predetermined mark on the workpiece.

To perform a miter cut:

1. DISCONNECT THE SAW FROM POWER!
2. Ensure that the blade guard/splitter is installed.
3. Determine the angle of your cut. If the angle needs to be very precise, use a protractor to set the miter gauge to the blade.
4. Place the face of the miter gauge against the edge of the workpiece and place the bar across the face of the workpiece. Use the bar as a guide to mark your cut, as shown in **Figure 58**.

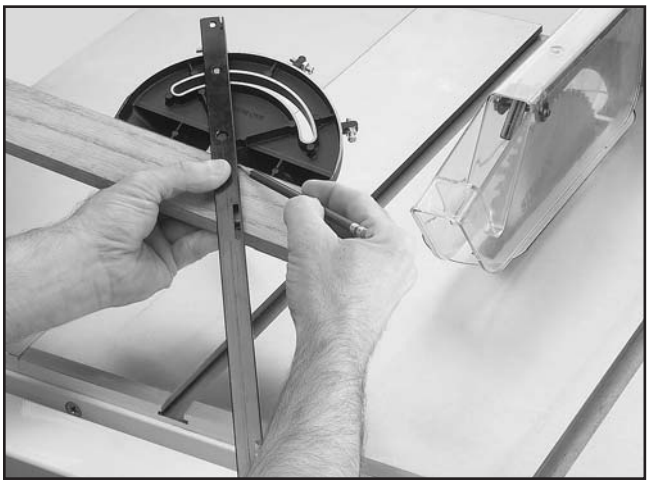


Figure 58. Example of marking miter line.

5. Place the miter gauge back into the slot and hold the workpiece firmly against the miter gauge body. Slide the miter gauge near the blade and adjust the workpiece so the blade will cut on the waste side of the line.
6. Proceed to make the cut in the same manner as described in the **Crosscutting** instructions.

Blade Tilt/Bevel Cuts

When the blade tilt stop bolts are properly adjusted (**Page 53**), the blade tilt handwheel allows the operator to tilt the blade to the left, anywhere between 0° and 45°. This is used most often when cutting bevels, compound miters or chamfers. **Figure 59** shows an example of the blade when tilted to 45°.

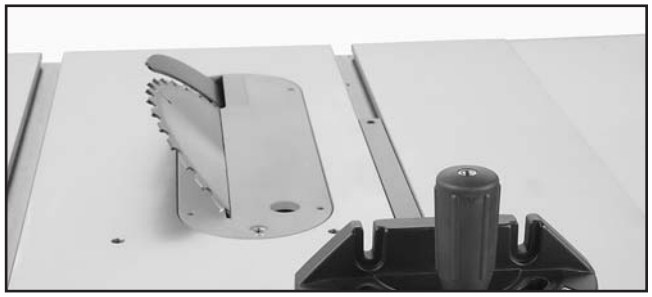


Figure 59. Blade tilted to 45° for bevel cutting on a typical table saw.

Dado Cutting

Commonly used in furniture joinery, a dado is a straight channel cut in the face of the workpiece. Dadoes can be cut using either a dedicated dado blade or a standard saw blade. The optional dado insert, Model H9910 (see **Page 46**), must be installed and used during dado cutting—unless a zero clearance table insert is used instead.

The table saw motor is pushed to its limits when making a dado cut with a dado blade. If the motor starts to bog down, slow down your feed rate and make multiple shallow passes. **DO NOT use a dado blade larger than 8" in diameter!** The saw and arbor are not intended to safely use a larger dado blade.

⚠WARNING

Dado operations require proper procedures to avoid serious injury. Extra care must be taken to prevent kickback when using dado blades. Any movement of the workpiece away from the fence will cause kickback. Be certain that stock is flat and straight. Failure to follow these warnings could result in serious personal injury.

⚠WARNING

DO NOT make a through-cut with a dado blade. Dado blades are not designed for through cuts. Failure to follow this warning could result in serious personal injury.

⚠CAUTION

Always use push sticks, featherboards, push paddles and other safety accessories whenever possible to increase safety and control during operations that require the blade guard and splitter to be removed from the saw. ALWAYS replace the blade guard after dadoing is complete.

Using a Stacked or Wobble Dado Blade

1. DISCONNECT THE SAW FROM POWER!
2. Remove the table insert, the blade guard assembly or riving knife, and the saw blade.
3. Attach and adjust the dado blade system according to the dado blade manufacturer's instructions. **DO NOT use a dado blade larger than 8" in diameter on this saw!** The saw and arbor are not intended to safely use a larger dado blade.
4. Install the dado table insert, making sure the center section of the insert has already been removed—so the blade can be raised correctly in the next step.
5. Raise the dado blade up to the desired depth of cut (depth of dado channel desired). When cutting deep dadoes, make multiple shallow passes to reduce the risk of kickback.

⚠WARNING

The danger of kickback increases relative to the depth and width of a cut. Reduce the risk of kickback by making multiple shallow cuts to achieve the desired depth of cut. Failure to follow these warnings could result in serious personal injury.

6. Adjust the distance between the fence and the inside edge of the blade, as shown in **Figure 60**, to dado the length of a workpiece.

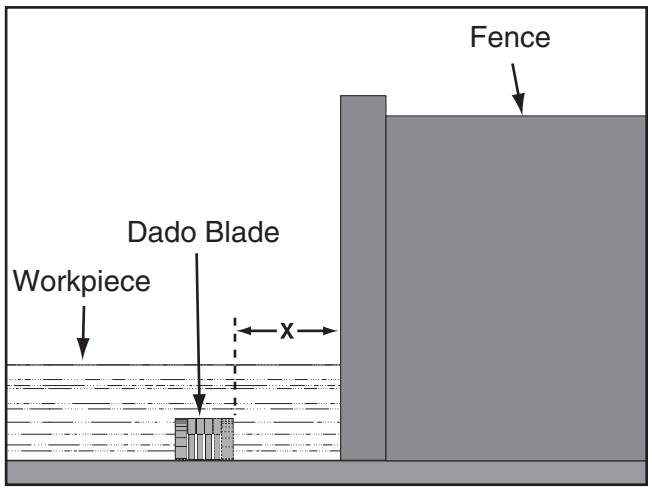


Figure 60. Stacked or wobble dado cut.

7. If dadoing across the workpiece, use the miter gauge and carefully line up the desired cut with the dado blade. DO NOT use the fence in combination with the miter gauge.

⚠WARNING

Never try to dado a board that is not flat by holding it down against the table. If kickback occurs, your hand will likely be pulled into the blade, resulting in serious personal injury.

⚠CAUTION

Always use push sticks, featherboards, push paddles and other safety accessories whenever possible to increase safety and control during operations that require the blade guard and splitter to be removed from the saw. ALWAYS replace the blade guard after dadoing is complete.

8. Reconnect the saw to the power source.

9. Turn the saw ***ON.*** The blade should run smooth, with no vibrations.

10. When the blade has reached full speed, perform a test cut with a scrap piece of wood.

11. If the cut is satisfactory, repeat the cut with the actual workpiece.

Using a Standard Saw Blade to Cut Dadoes

Note: *Reduce motor overloading and blade wear by using a ripping blade. Ripping blades are designed to clear the sawdust quickly. See* ***Page 33*** *for more details.*

To cut a dado with a standard blade:

1. DISCONNECT THE SAW FROM POWER!

2. Ensure that the riving knife and standard table insert are installed and properly adjusted.

3. Mark the width of the dado cut on the workpiece. Include marks on the edge of the workpiece so the cut path can be aligned when the workpiece is lying on the table. Raise the blade up to the desired depth of cut (depth of dado channel desired). When cutting deep dadoes, make multiple shallow passes to reduce the risk of kickback.

⚠WARNING

The danger of kickback increases relative to the depth and width of a cut. Reduce the risk of kickback by making multiple shallow cuts to achieve the desired depth of cut. Failure to follow these warnings could result in serious personal injury.

4. If dadoing across the workpiece, use the miter gauge to support the workpiece, and align the blade to cut one of the dado sides. DO NOT use the fence in combination with the miter gauge.

5. If dadoing the length of a workpiece, align the blade to cut one of the dado sides, as shown in **Figure 61**.

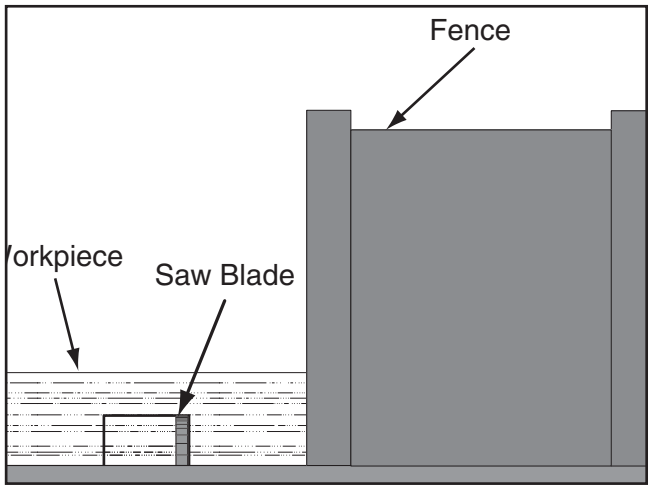


Figure 61. Single-blade dado first cut.

6. Reconnect the saw to the power source and turn the saw ***ON***. Allow the blade to reach full speed.

7. Perform the cutting operation.

8. Re-adjust the fence so the blade is aligned with the other edge of the intended dado channel (**Figure 62**).

Note: *Be sure to keep the cuts within your marks; otherwise, the dado will be too big.*

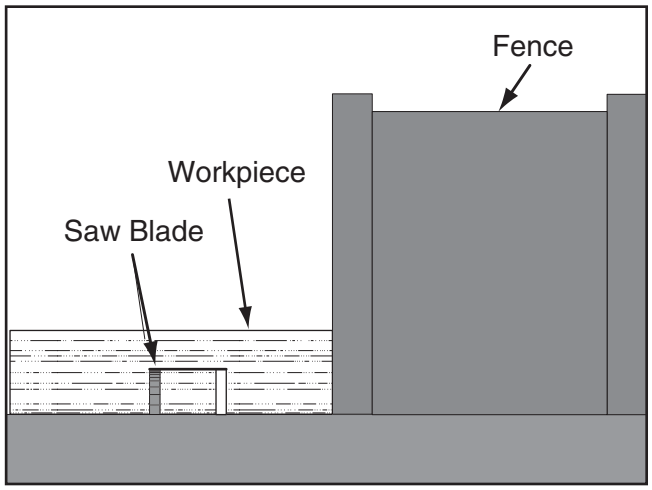


Figure 62. Single-blade dado second cut.

9. Continue making cuts toward the center of the dado until the dado is complete.

Rabbet Cutting

⚠WARNING

You may experience kickback during this procedure. Stand to the side of the blade and wear safety glasses or a face shield to prevent injury when cutting rabbets. Do not put hands behind blade!

Commonly used in furniture joinery, a rabbet is an L-shaped groove cut in the edge of the workpiece. Rabbets can be cut with either a dado blade or a standard saw blade.

Note: *Rabbet cutting requires the use of a sacrificial fence attachment, as shown in **Figure 63**.*

Cutting Rabbets with Dado Blade

1. DISCONNECT THE SAW FROM POWER!

2. Lower the blade completely, then install the dado blade and dado table insert or a zero clearance insert. **DO NOT use a dado blade larger than 8" in diameter on this saw!**

3. Make the sacrificial fence the same length as the fence and ¾" thick.

4. Attach the sacrificial fence to the rip fence with clamps, as shown in **Figure 63**, making sure they are all secure and tight.

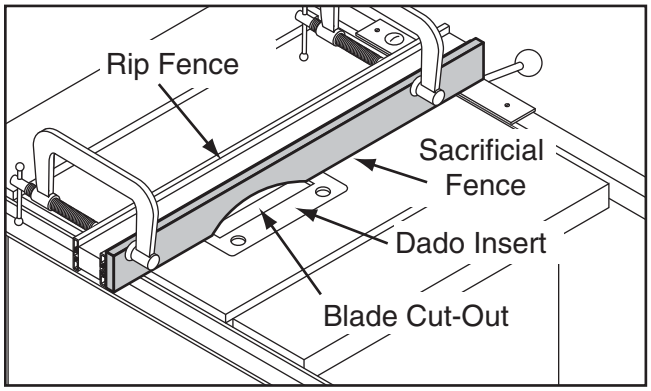


Figure 63. Sacrificial fence.

5. Adjust the fence, turn the saw ***ON***, raise the blade into the sacrificial fence to the height needed for the rabbeting operation, and turn the saw ***OFF***.

6. DISCONNECT THE SAW FROM POWER!

⚠CAUTION

Use push sticks, featherboards, push paddles and other safety accessories whenever possible to increase safety and control during operations that require the blade guard and splitter to be removed from the saw. ALWAYS replace the blade guard after dadoing is complete.

7. Align the workpiece to perform the cutting operation, as shown in **Figure 64**.

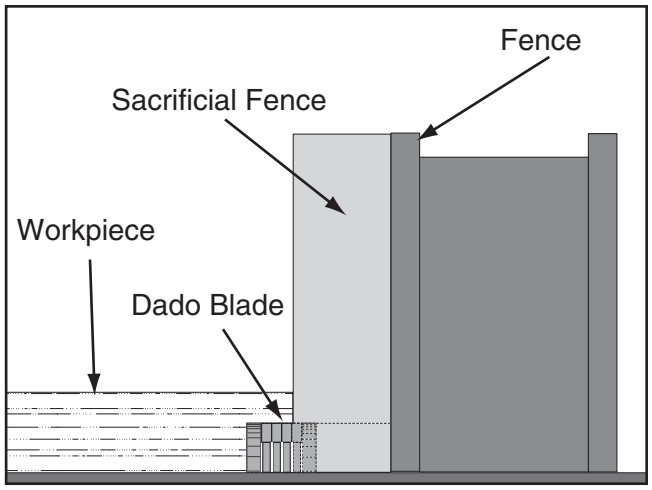


Figure 64. Rabbet cutting.

⚠WARNING

The danger of kickback increases relative to the depth and width of a cut. Reduce the risk of kickback by making multiple passes to achieve the desired depth of cut. Failure to follow these warnings could result in serious personal injury.

8. Reconnect the saw to the power source and turn the saw ***ON***.

9. When the blade has reached full speed, perform a test cut with a scrap piece of wood.

10. If the cut is satisfactory, repeat the cut with the final workpiece.

Cutting Rabbets with Standard Blade

Note: *Reduce motor overloading and blade wear by using a ripping blade. Ripping blades are designed to clear the sawdust quickly.*

To cut a rabbet with a standard blade:

1. DISCONNECT THE SAW FROM POWER!

2. Ensure that the riving knife and standard insert are installed.

3. Mark the width of the rabbet cut on the workpiece.

   Note: *Include marks on the edge of the workpiece to identify the intended cut while it is laying flat on the saw table.*

4. Raise the blade up to the desired depth of cut (depth of rabbet channel desired). When cutting deep rabbets, take more than one pass to reduce the risk of kickback.

⚠WARNING

The danger of kickback increases relative to the depth of a cut. Reduce the risk of kickback by making multiple passes to achieve the desired depth of cut. Failure to follow these warnings could result in serious personal injury.

5. Stand the workpiece on edge as shown in **Figure 65**.

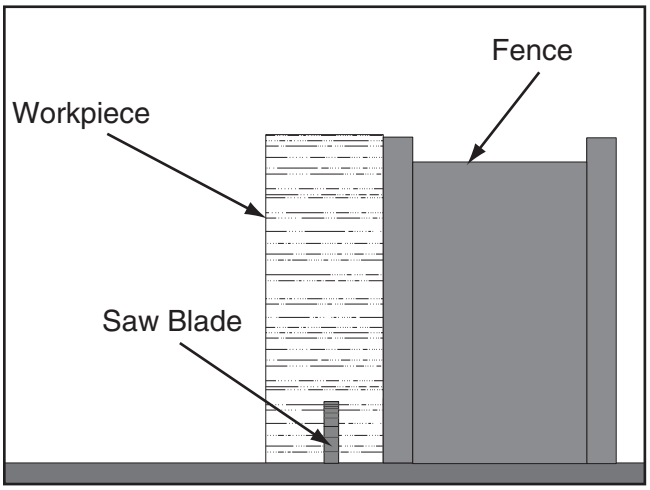


Figure 65. Rabbet cutting with a standard blade.

6. Reconnect the saw to the power source and turn the saw ***ON***.

7. When the blade has reached full speed, perform a test cut with a scrap piece of wood.

8. If the cut is satisfactory, repeat the cut with the final workpiece.

9. Adjust the fence so the blade is aligned with the inside of your rabbet channel, as shown in **Figure 66**.

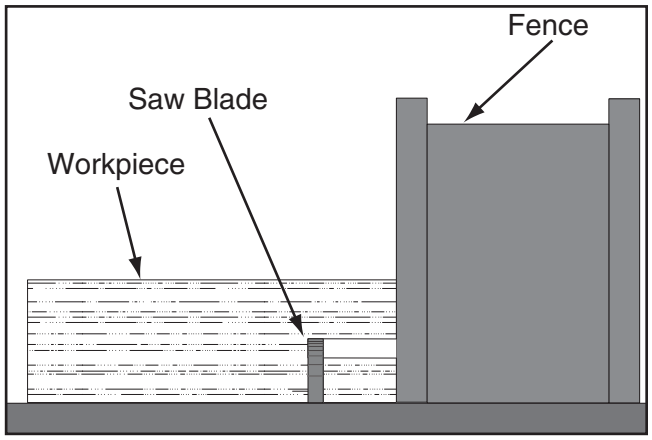


Figure 66. Second cut to create a rabbet.

10. Adjust the saw blade height to intersect with the first cut.

11. Perform the second cut to complete the rabbet.

Resawing

⚠WARNING

Resawing on a table saw increases the chances of kickback. Serious injury can be caused by kickback. Kickback is a high-speed expulsion of stock from the table saw toward an operator. The operator or bystanders may be struck by flying stock, or the operator's hands can be pulled into the blade during kickback.

⚠WARNING

Resawing operations require proper procedures to avoid serious injury. Extra care must be taken to prevent kickback when resawing. Any tilting or movement of the workpiece away from the fence will cause kickback. Be certain that stock is flat and straight. Failure to follow these warnings could result in serious personal injury.

Resawing is the process of cutting a thick piece of stock into one or more thinner pieces. **Bandsaws are ideal for resawing and the process is fairly easy and safe. A table saw is not intended for resawing and the process is difficult and extremely dangerous.** Resawing on the table saw often binds the blade, causing kickback. The risk of kickback increases relative to the depth of a cut. Kickback is more dangerous when resawing on a table saw because the anti-kickback devices and blade guard must be removed, leaving no protection between your hands and the saw blade. Kickback can pull the operator's hands into the blade, or the operator or bystanders may be hit by flying stock. DO NOT resaw on a table saw without using a resaw barrier. DO NOT resaw on a table saw without wearing a full face shield.

The following instructions describe how to build a resaw barrier, add an auxiliary fence to your standard fence, and more safely perform resawing operations.

Note: This table saw can only resaw wood that is less than 8" tall.

Resaw Barrier

The resaw barrier shown in **Figure 67** holds the workpiece vertical, keeps it aligned with the fence, and keeps your hands away from the blade.

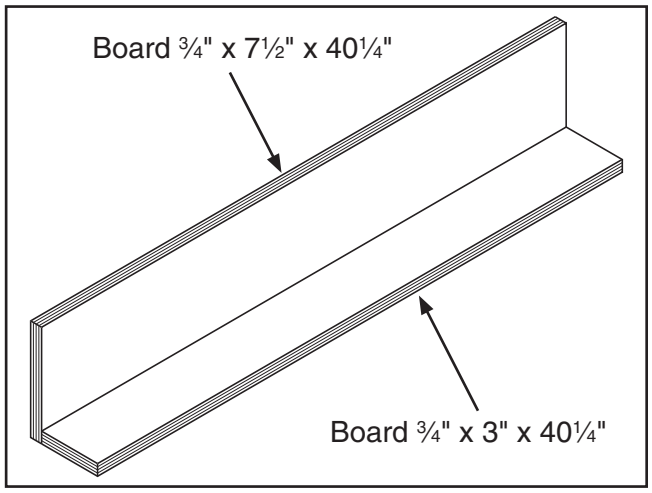


Figure 67. Resawing barrier.

Components Needed for the Resaw Barrier:
Hardwood or Plywood ¾" x 7½" x 40¼" 1
Hardwood or Plywood ¾" x 3" x 40¼" 1
Wood Screws ¼-20 x 2" 8
Wood Glue .....As Needed

Tools Needed for the Resaw Barrier:
Table Saw 1
Jointer and Planer ..... Recommended
Clamps .....2 Minimum
Drill and Drill Bits.....1

To build the resaw barrier:

1. Cut two boards to ¾" x 7½" x 40¼" and ¾" x 3" x 40¼". If you are using hardwood, cut the boards oversize, then joint and plane the boards to the correct size to make sure the boards are square and flat.

Note: *Only use furniture grade plywood or kiln dried hardwood to prevent warping.*

2. Pre-drill and countersink 8 holes approximately ⅜" from the bottom of the 7½" tall board. These will be used as pilot holes when attaching the board to another piece in the next step.

3. Glue the end of the 3" board, then clamp the boards at a 90° angle with the larger board in the vertical position, as shown in **Figure 68**.

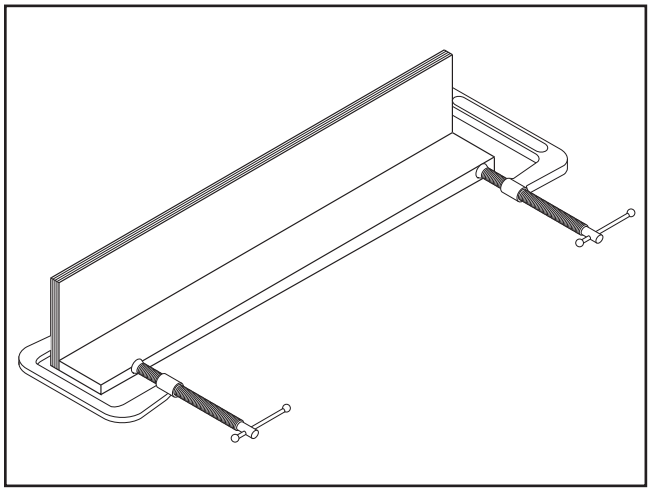


Figure 68. Clamping the resawing barrier.

4. Secure the joint with wood screws through the holes you drilled in **Step 2**.

Auxiliary Fence

The auxiliary fence is necessary if you are resawing a workpiece that is taller than it is wide. It should be no less than ½" shorter than the board to be resawn.

Components Needed for the Auxiliary Fence:
Hardwood or Plywood ¾" x (Height) x 40¼".....1
Flat Head Screws M8-1.25 x 25 (Not included) .4
Hex Nuts M8-1.25 (Included) 4

Tools Needed for the Resaw Barrier:
Table Saw 1
Jointer and Planer ..... Recommended
Clamps .....2 Minimum
Drill and Drill Bits 1

To build the auxiliary fence:

1. Cut a ¾" thick board 40¼" long, and cut a height no less than ½" shorter than the board to be resawn. If you are using hardwood, cut the board oversize, then joint and plane the board to the correct size to make sure the board is square and flat.

Note: *Only use furniture grade plywood or kiln-dried hardwood to prevent warping.*

2. Pre-drill and countersink four holes 1¼" from the bottom of the board.

3. Pull an end cap off of the standard fence, then remove four hex nuts, flat washers, hex bolts and one side of the fence facing from the fence body.

4. Thread the flat head screws through the auxiliary fence and into the hex nuts in the standard fence body, and tighten securely, as shown in **Figure 69**.

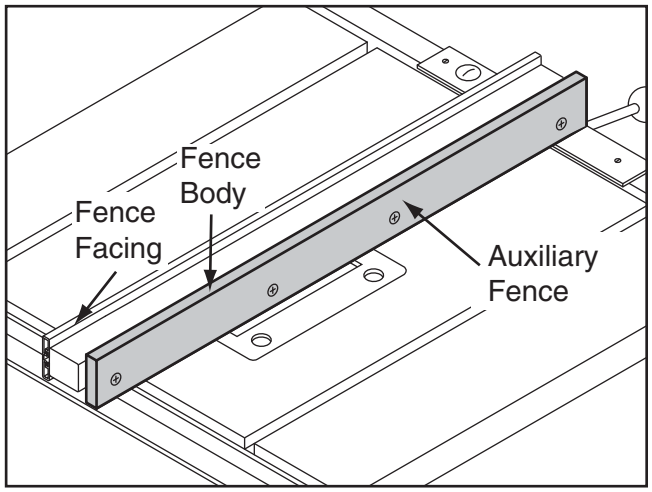


Figure 69. Auxiliary fence.

Resawing Operations

The table saw motor is pushed to its limits when resawing. If the motor starts to bog down, slow down your feed rate. Motor overloading and blade wear can be reduced by using a ripping blade. Ripping blades are designed to clear the sawdust quickly.

Components Needed for Resawing:

Zero Clearance Insert.....1
Ripping Blade 12".....1
Clamps 2
Shop Made Auxiliary Fence 1
Shop Made Resaw Barrier 1

⚠WARNING

You may experience kickback during this procedure. Stand to the side of the blade and wear a full face shield to prevent injury when resawing.

To perform resawing operations:

1. DISCONNECT THE SAW FROM POWER!

2. Remove the standard table insert and the blade guard assembly.

3. Install a ripping blade, install the riving knife, lower the blade below the table, then install the optional Model H991 zero clearance table insert.

4. Attach the auxiliary fence to the standard fence and set it to the desired width.

   Note: *When figuring out the correct width, don't forget to account for blade kerf and the inaccuracy of the fence scale while the auxiliary fence is installed.*

5. Place the workpiece against the auxiliary fence and slide the resaw barrier against the workpiece, as shown in **Figure 70**. Now clamp the resaw barrier to the table at both ends.

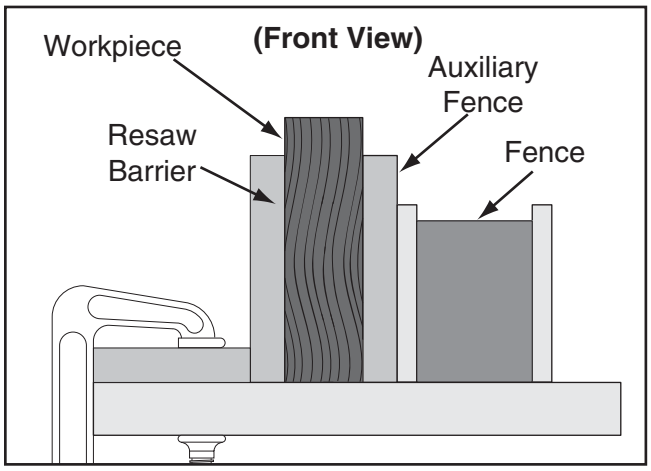


Figure 70. Ideal resaw workpiece setup.

6. Slide the workpiece over the blade to make sure it moves smoothly, then remove the workpiece.

7. Raise the blade approximately an inch, or close to half the height of the workpiece (**Figure 71**), whichever is less.

⚠WARNING

The danger of kickback increases relative to the depth of a cut. Reduce the risk of kickback by making multiple passes to achieve the desired depth of cut. Failure to follow these warnings could result in serious personal injury.

⚠CAUTION

Always use push sticks or push paddles to increase safety and control during operations which require that the blade guard and splitter must be removed from the saw. ALWAYS replace the blade guard after resawing is complete.

8. Plug in the table saw, turn it ***ON***, and use a push stick to feed the workpiece through the blade, using a slow and steady feed rate.

9. Flip the workpiece end for end, keeping the same side against the fence, and run the workpiece through the blade.

10. Repeat **Steps 7–9** until the blade is close to half of the height of the board to be resawn. The ideal completed resaw cut will leave an ⅛" connection when the resawing is complete as shown in **Figure 71**. Leaving an ⅛" connection will reduce the risk of kickback.

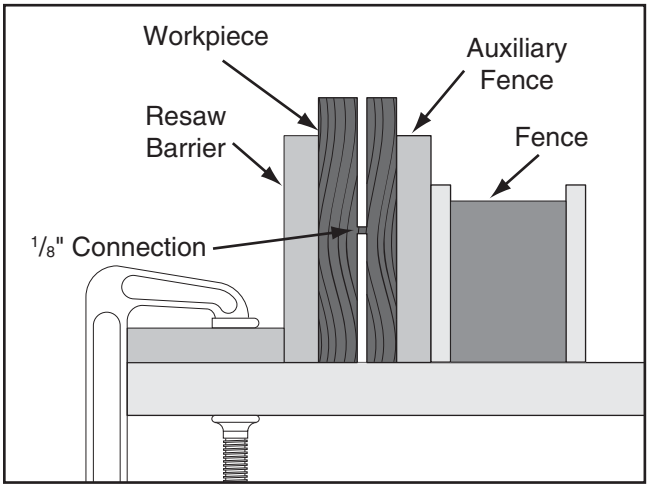


Figure 71. Ideal completed resaw cut.

11. Turn ***OFF*** the table saw, then separate the parts of the workpiece and hand plane the remaining ridge to remove it.

12. When finished resawing, remove the resaw barrier and auxiliary fence, then re-install the blade guard/splitter or riving knife and standard table insert.

SECTION 5: ACCESSORIES

Aftermarket Accessories

H8084—Rear Tool Box for G0605X1/G0606X1
H8085—Front Tool Box for G0605X1/G0606X1
Made specially to fit the G0605X1/G0606X1 saws. These heavy-duty tool boxes feature powder coated paint and ball bearing slides. Model H8084, 32"L x 22½"H x 15"D; Model H8085, 25"L x 22½"H x 15"D.

Figure 72. Model H8084, H8085 Tool Boxes.

G7314—Heavy-Duty Mobile Base
G8684—Extension Kit for Mobile Base
This heavy duty mobile base is rated for up to a 600 lb. capacity.

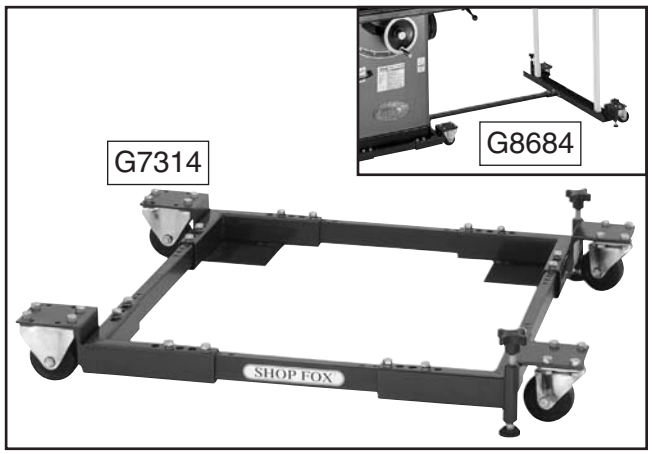


Figure 73. G7314 mobile base and extension kit.

H9910—Phenolic Dado Insert for G0696X/G06967X/G0605X1/G0606X1

H9911—Zero Clearance Insert for G0696X/G06967X/G0605X1/G0606X1
Made especially for the G0605X1/G0606X1/G0696X/G0697X table saw. Height is easily adjustable. Special phenolic material.

Carbide-Tipped Saw Blades (ATB)
G4808—12" Ripping, 40T
G4809—12"General Purpose, 60T
G4810—12" Fine Finishing/Cabinet Work, 80T
These ATB blades are manufactured to close tolerances and are fully balanced before leaving the factory. All the carbide-tipped teeth are precisely ground to give a smooth cut every time. The pattern of the teeth is alternate top bevel and the saw kerf is approx. ⅛". These blades have proven themselves in thousands of cabinet shops around the country. Manufactured for heavy-duty use.

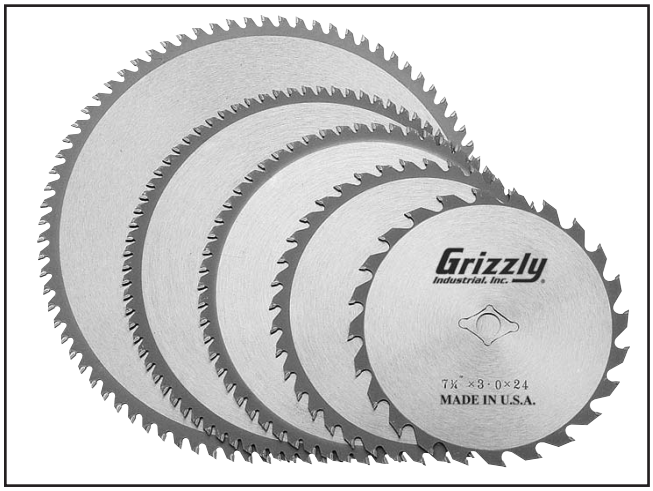


Figure 74. Carbide-tipped saw blades.

H7583—Grizzly Tenoning Jig
Our fully adjustable tenoning jig handles stock up to 3¼" thick and features an adjustable bevel angle with a 90° to 75° range. The two large grip handles, adjustable guide bar, multi-position control levers, and extra large clamping handwheel will ensure accurate and repeatable results. A top seller!

Call 1-800-523-4777 To Order

G1316—15" Wide Outfeed Roller System
G1317—37" Wide Outfeed Roller System
These unique roller systems fold down easily without tools and snap up in place quickly when needed. Both units have a double level system which lets you set the rollers either in line with the table or slightly below it.

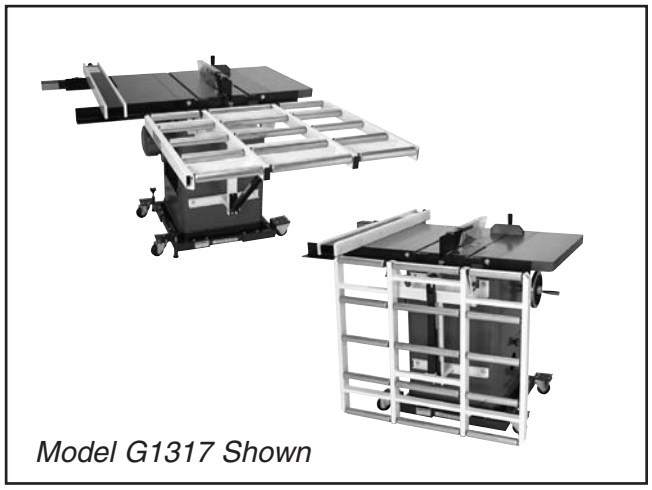

Model G1317 Shown

Figure 75. Outfeed roller system.

G4173—Baby Power Feeder 110V
G4176—¼ HP Power Feeder 110V
G4179—½ HP Power Feeder 220V
G4181—1 HP Power Feeder 220V
Installing a power feeder on your table saw will make repetitive cuts much easier and safer. Can be installed on nearly any table saw. Easy to adjust wherever needed, including out of the way when not needed! A must for any production shop.

Figure 76. G4179 Power Feeder.

G2370—SHOP FOX® Board Buddies
These unique holddowns only turn in one direction to prevent kickback. Adjustable height, spring loaded wheels are designed to hold your workpiece tight against the table and rip fence and are made of a special composition that will not mark your work.

Figure 77. G2370 SHOP FOX® Board Buddies.

H7777—Grizzly 8" Stack Dado Set
Finally, a stack dado set that everyone can afford! The set includes two 1/8" wide 30 tooth blades, four 1/8" wide chip cutters, one 3/32" wide chip cutter, one 1/16" wide chip cutter and two each copper shims in .005", .010", .015" and .020" thicknesses. Bore is 5/8". Can cut dadoes from 1/8" to 3/4".

Figure 78. H7777 Grizzly stack dado set.

Shop Made Safety Accessories

Push Stick

Using a push stick is essential to safe table saw operations, especially when cutting narrow cuts. The beauty of a push stick is that it keeps your hand well away from the blade during the cut, and if there is contact with the blade, the push stick will take the damage rather than your fingers or hand.

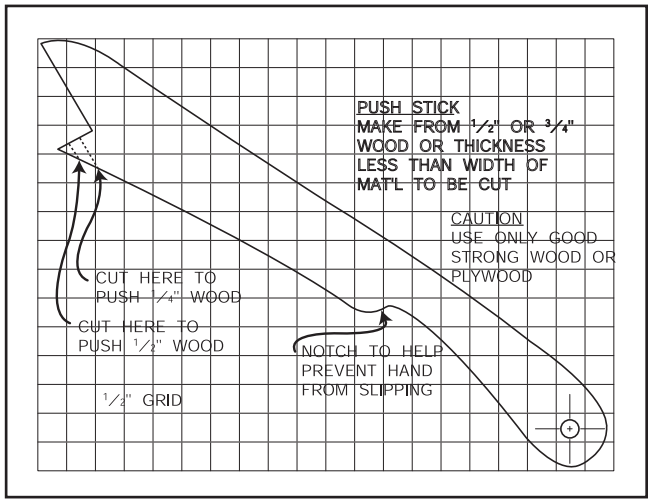


Figure 79. Shop made push stick.

Featherboard

Not only do featherboards make great anti-kickback devices, but they maintain pressure on the workpiece while cutting, which makes operation easier and safer because the cut can be completed without the operator's hands getting near the blade. When used together with push sticks, the overall risk of injury can be greatly reduced.

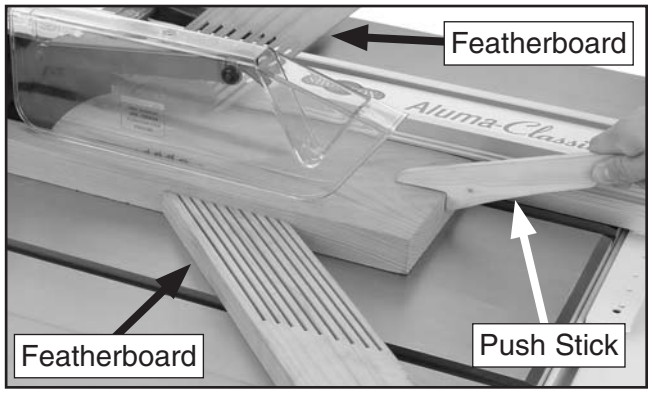


Figure 80. Examples of featherboards in use.

Outfeed & Support Tables

One of the best accessories for improving the safety and ease of using your G0696X/G0697X table saw is simply placing a large table (outfeed table) behind the saw to catch the workpiece. Additionally, another table to the left or right of the saw (support table) can also help support large workpieces so they can be cut safely and accurately.

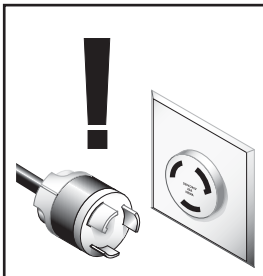
Figure 81. Example of outfeed & support tables.

Crosscut Sled

A crosscut sled is a fantastic way to improve the safety and accuracy of crosscutting on the table saw. Most expert table saw users use a crosscut sled when they have to crosscut a large volume of work, because the sled offers substantial protection against kickback.

Figure 82. Example of crosscut sled.

SECTION 6: MAINTENANCE



⚠WARNING

Always disconnect power to the machine before performing maintenance. Failure to do this may result in serious personal injury.

Schedule

For optimum performance from your machine, follow this maintenance schedule and refer to any specific instructions given in this section.

Daily Check:
- Inspect blades for damage or wear.
- Check for loose mounting bolts/arbor nut.
- Check cords, plugs, and switch for damage.
- Check for any other condition that could hamper the safe operation of this machine.
- Wipe the table clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces.

Weekly Maintenance:
- Wipe down the table surface and grooves with a lubricant and rust preventive such as SLIPIT®.
- Vacuum dust buildup from the motor housing and trunnions.
- Clean the pitch and resin from the saw blade with a cleaner like OxiSolv® Blade & Bit Cleaner.

Monthly Maintenance:
- Check/tighten the belt tension (**Page 63**).

Cleaning

Cleaning the Model G0605X1/G0606X1G0696X/G0697X is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it.

After cleaning, treat all unpainted cast iron and steel with a non-staining lubricant.

Occasionally it will become necessary to clean the internal parts with more than a vacuum. To do this, remove the table top and clean the internal parts with resin/pitch dissolver or mineral spirits and a stiff wire brush or steel wool. DO NOT USE WATER—WATER WILL CAUSE CAST IRON TO RUST.

Make sure the internal workings are dry before using the saw again, so that wood dust will not accumulate. If any essential lubrication is removed during cleaning, re-lubricate those areas.

Lubrication

An essential part of lubrication is cleaning the components before lubricating them.

This step is critical because dust and chips build up on lubricated components, which makes them hard to move. Simply adding more grease to built-up grime will not result in smooth moving parts.

Clean the components in this section with an oil/grease solvent cleaner, such as shown on **Page 18** of this manual.

The following are the main components that need to be lubricated:

- Trunnion Slides
- Worm Gear, Bevel Gears, and Mounting Plate Teeth
- Elevation Leadscrew and Rails

DISCONNECT THE POWER BEFORE PERFORMING LUBRICATION!

After lubrication is complete, recalibrate the digital readout (refer to procedure on **Page 62**) before operating the table saw.

Trunnion Slides

Clean the trunnion slides out with mineral spirits and a rag, and brush a dollop of lithium grease into each groove. Move the blade tilt back-and-forth to spread the grease (see **Figure 83**).

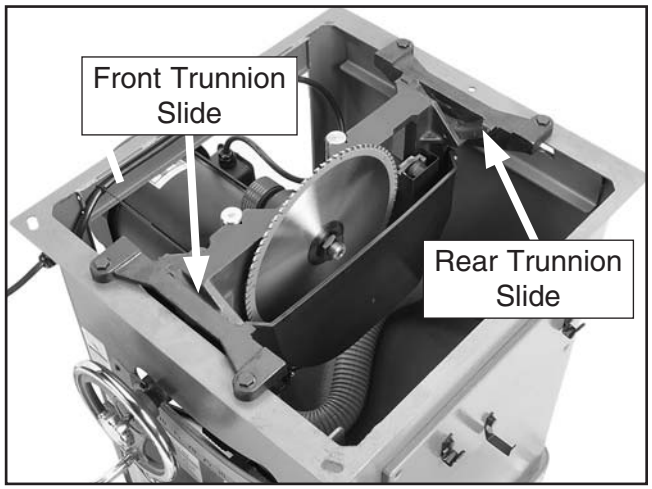


Figure 83. Trunnion slides and tilt leadscrew.

Worm Gear, Bevel Gears, and Mounting Plate Teeth

Use a wire brush and mineral spirits to clean away any built up grime and debris from the worm gear, bevel gear, and mounting plate teeth (**Figure 84**).

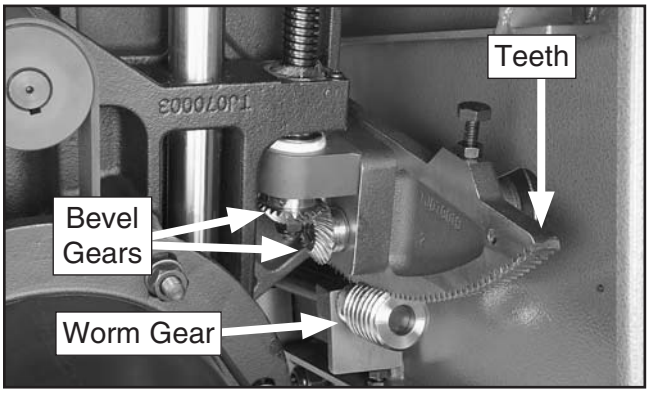


Figure 84. Worm gear, bevel gears, and mounting plate teeth.

Use a brush to apply a thin coat of white lithium grease to the worm gear, bevel gears, and mounting plate teeth.

Elevation Leadscrew and Rails

Clean away any built up grime and debris with a wire brush and mineral spirits from the elevation rails and elevation leadscrew (see **Figure 85**).

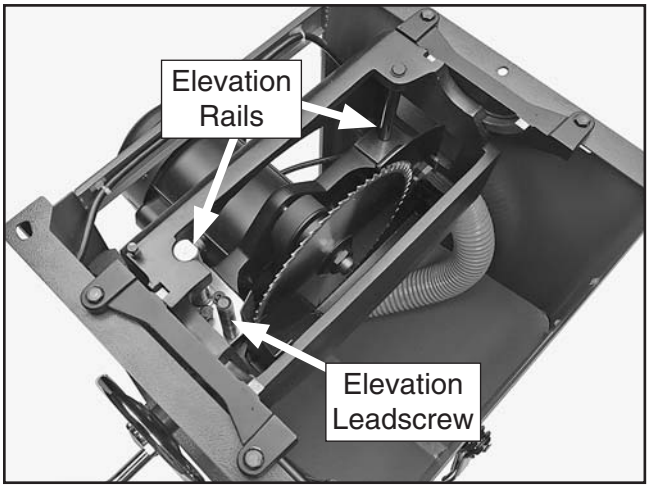


Figure 85. Bevel gears, elevation leadscrew and rails

Use a brush to apply lithium grease to the elevation leadscrew. Brush a small amount of grease (or oil) onto the elevation rails and wipe them down with a rag. The goal is to spread a thin film over the rails to help protect them from rust.

SECTION 7: SERVICE

Review the troubleshooting and procedures in this section to fix or adjust your machine if a problem develops. If you need replacement parts or you are unsure of your repair skills, then feel free to call our Technical Support at (570) 546-9663.

Troubleshooting

Symptom	Possible Cause	Possible Solution
Motor does not start.	1. Switch disabling key removed. 2. Motor connection wired incorrectly. 3. Contactor not energized/has poor contacts. 4. Tripped thermal overload on motor. 5. Break or short in wiring; or loose connections. 6. Power supply switched off/has incorrect voltage. 7. Thermal overload relay in mag switch tripped. 8. Start capacitor has blown (G0605X1/G0696X only). 9. Centrifugal switch at fault (G0605X1/G0696X only). 10. Machine wired out of phase (G0606X1/G0697X only). 11. Phase converter (if used) wild wire connected wrong (G0606X1/G0697X only).	1. Reinstall switch disabling key. 2. Wire motor correctly (refer to inside junction box cover or manual). 3. Test all legs for power, test field coil and replace if at fault. 4. Correct motor overload problem and reset. 5. Trace/replace broken or corroded wires; fix loose connections. 6. Switch power supply on/verify voltage. 7. Allow relay/motor to cool. If necessary, press reset button inside switch. 8. Test/replace if at fault. 9. Adjust/replace centrifugal switch. 10. Swap two power incoming power leads (**Page 28**). 11. Connect wild wire to line without transformer or sensitive electronics.
Machine operates in reverse.	1. Power connections wired out of phase (G0606X1/G0697X only).	1. Swap two incoming power leads (**Page 28**).
Machine has excessive vibration or noise.	1. Slight blade wobble. 2. Arbor nut is loose/obstructed by debris. 3. Arbor pulley loose. 4. Loose tilt handwheel. 5. Casting at fault. 6. Motor fan rubbing on fan cover. 7. Motor mounting loose. 8. Flat belt worn or damaged. 9. Belt(s) slapping cover. 10. Pulley loose or not in alignment; shaft bent. 11. Machine incorrectly mounted on floor. 12. Arbor bearings at fault. 13. Motor bearings worn or damaged.	1. Use a blade stabilizer. 2. Remove and clean, then tighten arbor nut. 3. Retighten/replace arbor pulley with shaft and thread locking liquid. 4. Tighten the tilt handwheel lock knob. 5. Trunnion/geared bearing housing is loose or cracked; tighten or replace. 6. Fix/replace fan cover; replace loose or damaged fan. 7. Tighten mounting bolts/nuts; use thread locking fluid. 8. Replace Flat-belt (refer to **Page 64**). 9. Tighten belt(s). 10. Replace worn pulley, key, and shaft, and realign. 11. Level/shim base; tighten/adjust mounting hardware or feet. 12. Replace arbor housing bearings; replace arbor. 13. Replace motor bearings or replace motor.

Symptom	Possible Cause	Possible Solution
Handwheel binds or is difficult to move.	1. Lock knob is engaged. 2. Handwheel shaft pins are wedged. 3. Handwheel is inserted too far. 4. Too much engagement between the worm gear & trunnion	1. Loosen lock knob. 2. Remove handwheel and adjust shaft pins. 3. Remove handwheel and adjust key. 4. Adjust worm gear engagement.
Blade does not reach 90 degrees.	1. Pointer or scale calibrated incorrectly. 2. 90 Degree stop bolt is out of adjustment.	1. Calibrate pointer/scale at true 90 degrees (**Page 53**). 2. Adjust 90 degree stop bolt (**Page 53**).
Blade does not reach 45 degrees.	1. Pointer or scale calibrated incorrectly. 2. 45 Degree stop bolt is out of adjustment. 3. Sawdust is built up in front trunnion.	1. Calibrate pointer/scale at true 45 degrees (**Page 53**). 2. Adjust 45 degree stop bolt (**Page 54**). 3. Check for sawdust in trunnions, clean and re-lubricate as necessary.
Blade too close to insert.	1. Blade position on arbor is incorrect. 2. Table mounting position is not centered.	1. Verify that blade arbor washers are correct and in the required position. 2. Loosen table mounting bolts, adjust table position, then realign the blade.
Blade will not go beneath table surface.	1. Handwheel shaft pins are wedged. 2. Roll pin/setscrew in worm gear contacting geared trunnion. 3. Handwheel key is inserted too far.	1. Remove handwheel and adjust shaft pins. 2. Tighten roll pins and setscrews in the worm gear. 3. Remove handwheel and adjust key.
Blade will not move up or down.	1. Set screw on worm gear is loose/missing. 2. Handwheel shaft key is missing.	1. Tighten or replace set screw. 2. Replace key.
Workpiece burns or binds when feeding.	1. Riving knife not correctly aligned with blade. 2. Splitter not correctly aligned with blade. 3. Fence not parallel with blade (pressure at blade backside). 4. Blade is warped or damaged. 5. Too many teeth on blade for cutting type	1. Adjust/shim riving knife into alignment with blade (**Page 57**). 2. Adjust/shim splitter into alignment with blade (**Page 57**). 3. Adjust fence parallel with blade (**Page 59**). 4. Replace blade (**Page 34**). 5. Change blade to one with fewer teeth
Too much sawdust blown back toward operator.	1. Blade guard has been removed. 2. Too many air leaks in cabinet for proper dust collection. 3. Dust collection system clogged; too weak. 4. Fence not parallel with blade (pressure at blade backside). 5. Miter slot/fence not parallel with blade at 90° and 45°.	1. Reinstall blade guard for maximum safety and dust control. 2. Seal leaks in cabinet or around dust chute. 3. Remove clog; revise ducting layout for improved suction. 4. Adjust fence parallel with blade (**Page 59**). 5. Adjust table/trunnions so miter slot is parallel with blade at 90° and 45° (**Page 55**).

Blade Tilt Stops

The table saw features bolts that stop the blade tilt exactly at 45° and 90° when using the handwheel. These stops have been set at the factory and should require no adjustments, unless you notice that your cuts are not accurate.

Note: *The tilt scale reads "0" when the blade is 90° to the table.*

Tools Needed	Qty
90° Square	1
45° Square	1
Hex Wrench 4mm	1
Wrench 13mm	1

Setting 90° Stop Bolt

1. DISCONNECT THE SAW FROM POWER!

2. Raise the blade as high as it will go, then tilt it toward 0° until it stops and cannot be tilted any more.

3. Place a 90° square against the table and blade so it contacts the blade evenly from bottom to top, as shown in **Figure 86**. Make sure a blade tooth does not obstruct the placement of the square.

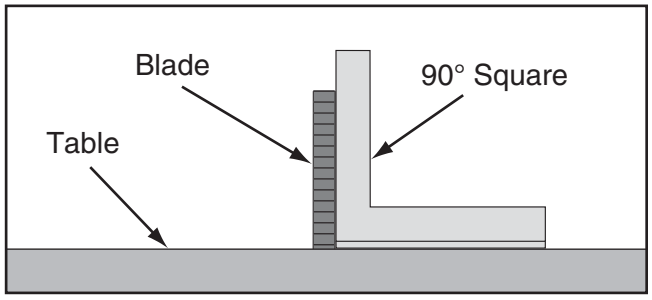


Figure 86. Checking blade at 90°.

—If the blade is 90° to the table, then adjustments do not need to be made. Make sure the tilt indicator arrow shown in **Figure 87** points to the 0° mark on the scale. If it does not, remove the blade height lock knob, loosen the blade height handwheel set screw and remove the handwheel. Adjust the indicator position by loosening the Phillips head screw, moving the indicator, then tightening the screw and reinstalling the handwheel. Proceed to ***Setting 45° Stop Bolt*** on **Page 54**.

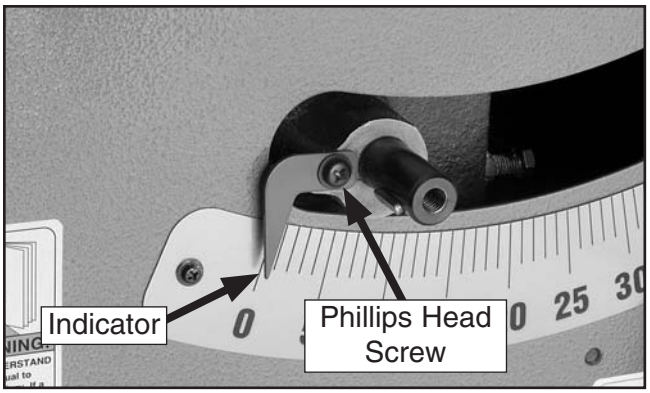


Figure 87. Tilt indicator arrow.

—If the blade is not 90° to the table, you will need to adjust the 90° stop screw. Proceed to the next step.

4. Tilt the blade away from 0° by about 5°, so there is room for the stop bolt to move.

5. Open the motor access cover, loosen the jam nut shown in **Figures 88** and **89**, adjust the stop bolt up or down according to how far off the blade was from 90°, then repeat **Step 3** until the blade stops at 90°.

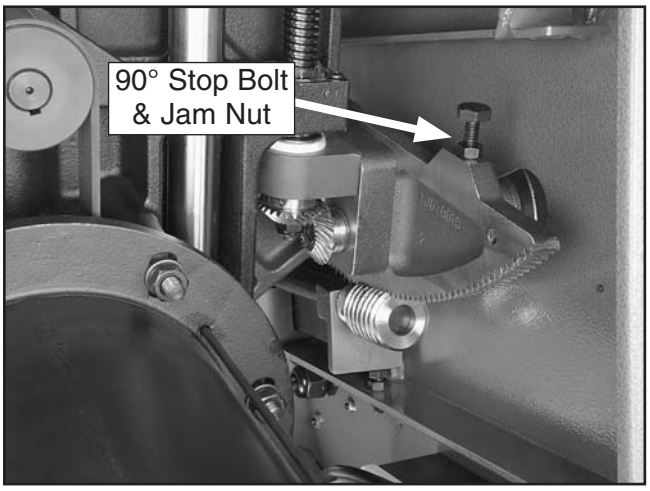


Figure 88. 90° stop bolt and jam nut.

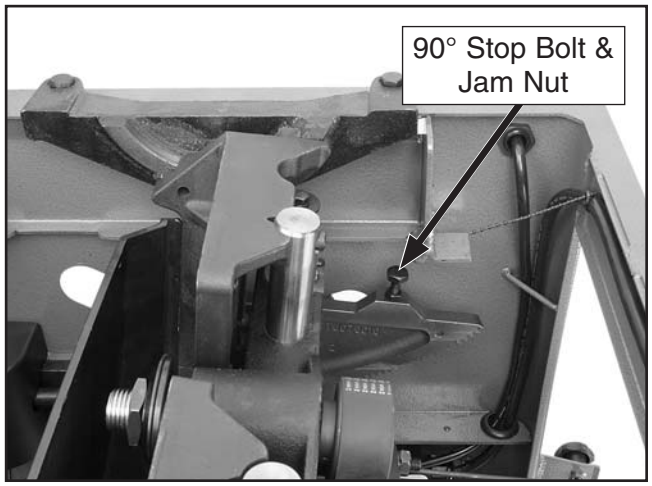


Figure 89. 90° stop bolt and jam nut (table removed for clarity).

6. Tighten the jam nut, then close the motor cover.

Setting 45° Stop Bolt

1. DISCONNECT THE SAW FROM POWER!

2. Raise the blade as high as it will go, then tilt it towards 45° until it stops and cannot be tilted any more.

3. Place a 45° square against the table and blade so it contacts the blade evenly from bottom to top, as shown in **Figure 90**. Make sure a blade tooth does not obstruct the placement of the square.

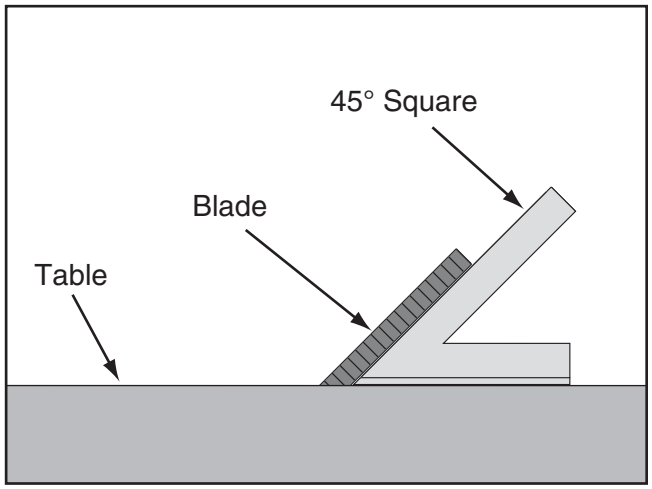


Figure 90. Checking blade at 45°.

—If the blade is 45° to the table, then adjustments do not need to be made.

—If the blade is not 45° to the table, you will need to adjust the 45° stop screw. Proceed to the next step.

4. Tilt the blade to 20°, so there is room for the stop bolt to move.

5. Loosen the jam nut on the 45° stop bolt (see **Figure 91**) with a 13mm wrench, then adjust the stop bolt up or down according to how far off the blade was from 45°.

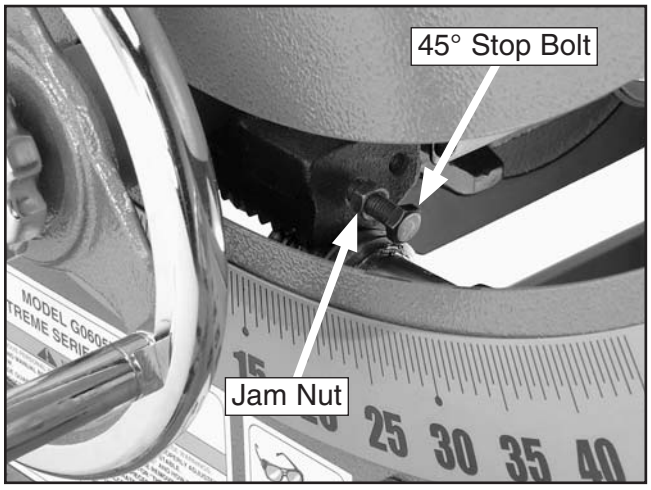


Figure 91. 45° stop bolt and jam nut.

6. Continue adjusting the stop bolt until it contacts the cabinet when the blade is at 45°, then tighten the jam nut.

7. Reconnect the power, then recalibrate the digital readout (refer to procedure on **Page 62**) before operating the table saw.

Miter Slot to Blade Parallelism

Tools Needed	Qty
Adjustable Square	1
Metal Shim Stock	As Needed
Marker	1
Wrench 17mm	1

Your table saw will give the best results if the miter slot is parallel with the blade. If these components are not exactly parallel with each other, your cuts and your finished work will be lower in quality, but more importantly, the risk of kickback will be increased.

To adjust the blade parallel with the miter slot:

1. DISCONNECT THE SAW FROM POWER!

2. Tilt the blade to 90°.

3. Measure from the miter slot to a carbide tip on the blade, as shown in **Figure 92.**

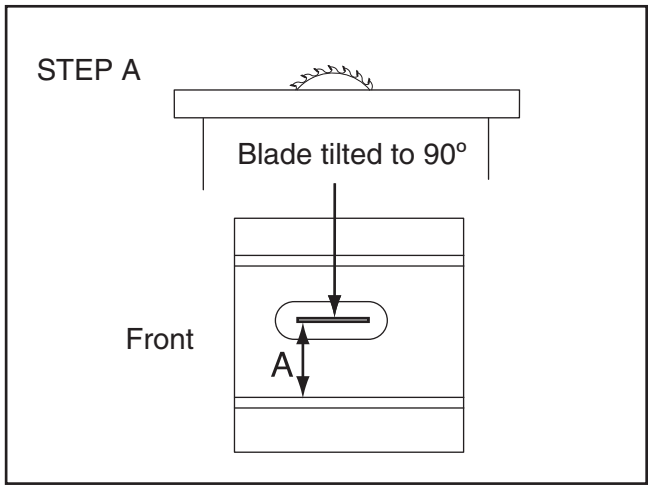


Figure 92. Measuring distance from miter slot to carbide tip of blade.

4. Mark the carbide tip with a marker where you made this measurement.

⚠CAUTION

The saw blade is dangerously sharp. Use extra care or wear gloves when handling the blade or working near it.

5. Rotate the marked blade tip to the other end of the table insert.

6. Compare the distance from the marked blade tip to the miter slot, as shown in **Figure 93**.

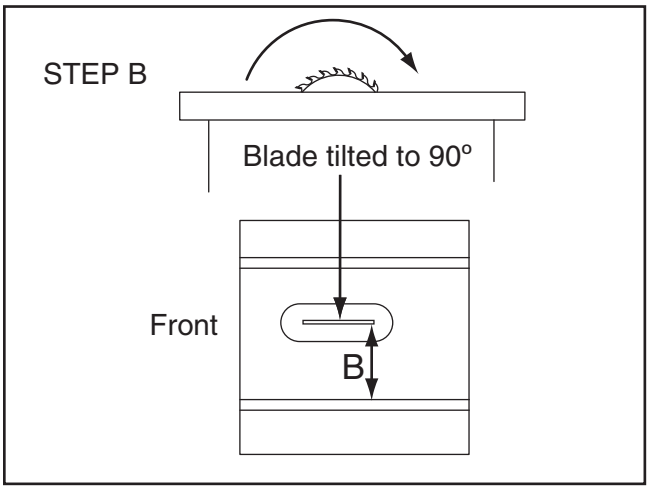


Figure 93. Measuring distance from miter slot to carbide tip on opposite side of table insert.

—If the distance between the blade tip and the miter slot is not the same on both sides of the table insert, the table will need to be adjusted. Proceed to **Step 7**.

—If the blade tip measurement is the same on both sides, go to **Step 8**.

7. To adjust the table, loosen the three bolts in the table mounting locations (see **Figure 94**) and lightly tap the table. Repeat **Steps 2-6** until the blade and miter slot are parallel. Do not forget to tighten the table mounting bolts when finished.

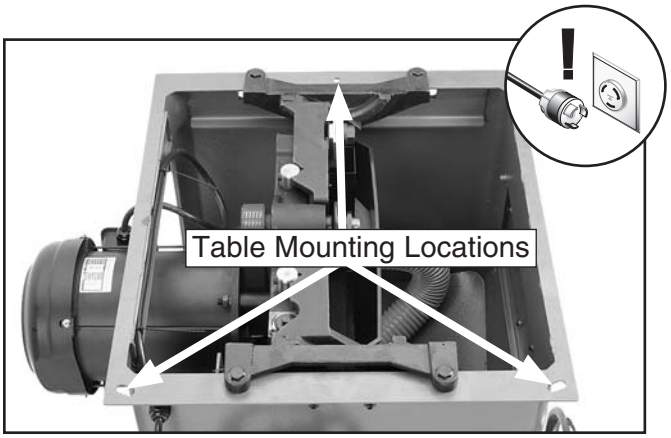


Figure 94. Table mounting bolt holes (table top removed for clarity).

8. Tilt the blade to 45° and repeat **Steps 3-6**.

—If the blade is still parallel with the miter slot, continue onto the **Blade Alignment** procedure.

—If the blade was parallel with the miter slot at 90° but not at 45°, one end of the table will need to be shimmed higher with metal shim stock.

9. Refer to **Figures 95 and 96** for shim placement. If the distance of A is shorter than B, shim(s) will need to be placed under corners #1 and #2. If the distance of B is shorter than A, shim(s) will need to be placed under corner #3. Very thin shim stock works well.

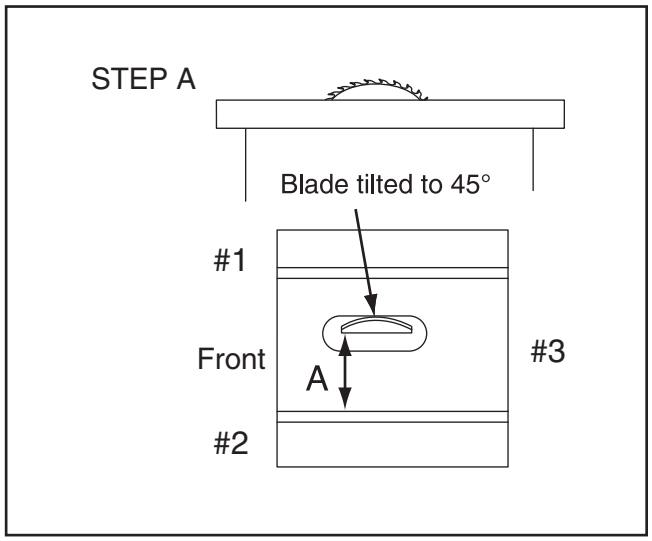


Figure 95. Shim procedure diagram A.

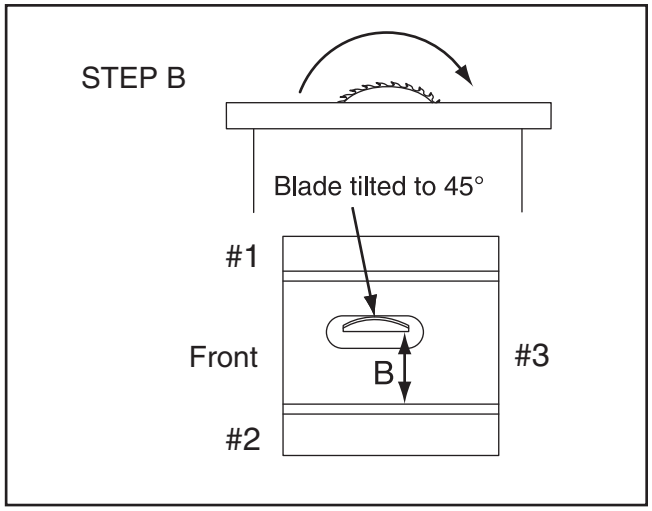


Figure 96. Shim procedure diagram B.

10. Tighten one bolt a small amount and then move on to each of the others, tightening each down the same amount. Continue to rotate through the bolts, tightening them a little each time until they are all secure.

11. Now recheck the blade to miter slot at 90° and 45° by repeating **Steps 3-6**.

—If the distance of A and B are equal, continue to **Step 12**, then go to **Blade Alignment**.

—If the distances are still off, repeat **Steps 9-11**.

12. Once the miter slot is adjusted to the blade, recheck all measurements and be sure the table mounting bolts are secure. Also, if you remove the table in the future, make note of the shim placements and reassemble exactly how it came apart.

13. Reconnect the power, then recalibrate the digital readout (refer to procedure on **Page 62**) before operating the saw.

Blade Alignment

If the blade contacts the table insert when raised or tilted, the blade must be aligned.

Tools Needed	**Qty**
Wrench 14mm	1

To adjust the blade alignment by moving the table:

1. DISCONNECT THE SAW FROM POWER!

2. Loosen the three table mounting bolts (**Page 55, Figure 94**) and adjust the table until the blade does not contact the insert. Tighten all the mounting bolts.

3. Make sure the blade does not contact the table insert when raised or tilted. Recheck parallelism of the blade to the miter slot (see **Page 55**). Adjust as necessary until the blade does not touch the insert.

Splitter or Riving Knife Alignment

Spreader Thickness	Size
Splitter	0.090"
Riving Knife	0.090"

Checking Splitter/Riving Knife Alignment

The blade guard splitter and riving knife must be aligned with the blade when installed. If the splitter/riving knife is not aligned with the blade, then the workpiece will before forced sideways during the cut, which will increase the risk of kickback.

Tools Needed	Qty
Straightedge	1

To check the splitter/riving knife alignment:

1. DISCONNECT THE SAW FROM POWER!

2. Raise the saw blade to the maximum height so you have easy working access.

3. Place the straightedge against the blade and the splitter/riving knife. When properly aligned, the splitter/riving knife will be in the "Alignment Zone," shown in **Figure 97**, and will be parallel with the blade.

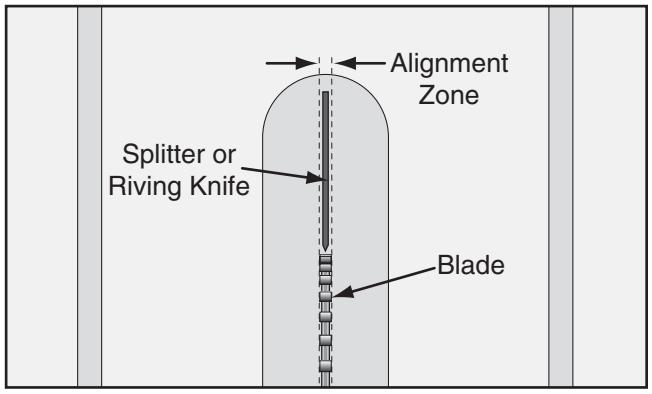


Figure 97. Splitter/riving knife alignment zone.

—If the splitter/riving knife is not inside the alignment zone, then it needs to be shimmed. Proceed to ***Shimming Splitter/Riving Knife*** instructions.

—If the splitter/riving knife is not parallel with the blade, then it needs to be straightened. Proceed to ***Straightening Splitter/Riving Knife*** instructions on **Page 58**.

Shimming Splitter/Riving Knife

The splitter/riving knife mounting position can be adjusted into alignment with the blade using metal shims.

Note: *These instructions require that you complete the **Checking Splitter/Riving Knife Alignment** instructions first and that the saw is disconnected from power and the blade is raised.*

Possible Tools Needed	Qty
Arbor Wrenches	2
Metal Shims	As Needed
Hex Wrench 6mm	1
Phillips Screwdriver #2	2

To shim the splitter/riving knife:

1. Remove the table insert.

2. Remove the splitter/riving knife by loosening the mounting bolt with the arbor wrench.

   Note: *Do not fully remove the mounting bolt because the shims you place in the next step will straddle the threads of the mounting bolt.*

3. Place three shims inside the mounting block, as in **Figure 98**, then reinstall the splitter/riving knife, and fully tighten the mounting bolt.

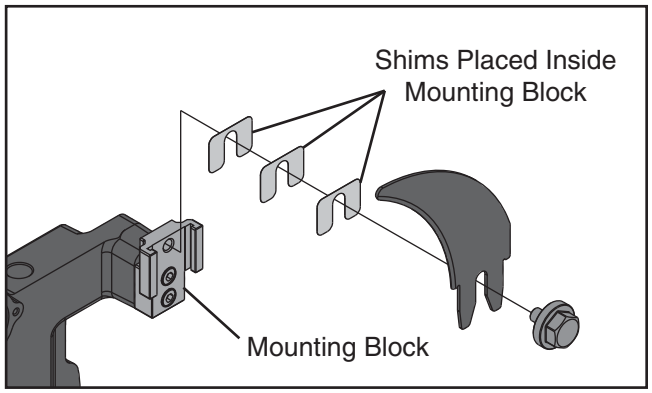


Figure 98. Shimming inside the block.

4. Check the alignment as you did previously.

—If the splitter/riving knife is in the alignment zone, no additional steps are necessary.

—If the splitter/riving knife is still not aligned with the blade, add or remove shims as necessary.

Straightening Splitter/Riving Knife

If the splitter or riving knife is not parallel with the blade, it is possible that it is bent.

To fix this, DISCONNECT THE SAW FROM POWER, bend the splitter or riving knife by hand (while installed) until it is aligned with the blade. If this doesn't work, remove it to straighten. If you cannot straighten it properly, just replace it.

Fence Adjustments

There are four main adjustments for the fence: square, height, parallelism, and clamping pressure. Keep in mind that these adjustments are interconnected and some trial-and-error may be needed to achieve satisfactory results.

Tools Needed	Qty
Hex Wrench 4mm	1
Hex Wrench 6mm	1
Machinist's Square	1
Felt-Tipped Marker	1

Square and Height

The fence face must be square to the table in order to produce square cuts. Also, the fence should be adjusted high enough off the table that it does not drag across the surface.

To check/adjust the fence height and squareness to the table:

1. DISCONNECT THE SAW FROM POWER!

2. Place a square on the table against the face of the fence (**Figure 99**) to check if the fence is square to the table.

—If the fence is not square to the table, proceed to **Step 3**.

—If the fence is square to the table, skip ahead to **Step 4**.

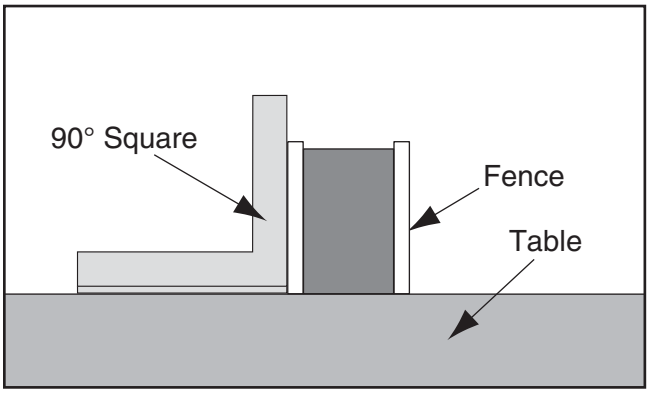


Figure 99. Checking if fence is square to table.

3. Adjust the set screws (**Figure 100**) on top of the fence bracket to ensure the fence face is 90° to the table.

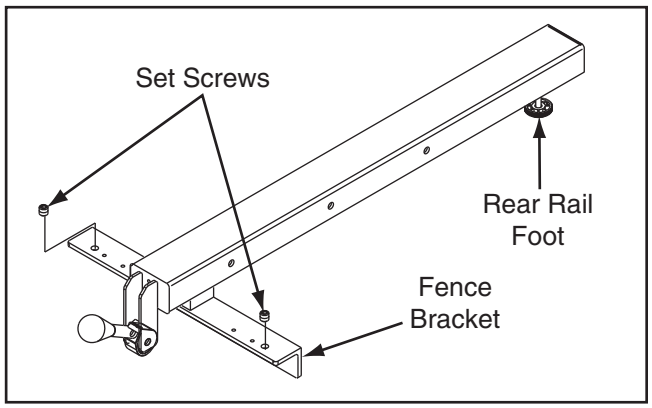


Figure 100. Fence components used to adjust fence height and squareness to table.

4. Look at the gap between the fence and the table top.

   —If the gap is approximately 1/16" and even from the front of the table to the back (see **Figure 101)**, then no additional adjustments are necessary. Proceed to **Clamping Pressure and Parallelism**.

   —If the gap is uneven, if the fence height is more than 1/8", or if the fence touches the table, then continue with **Step 5**.

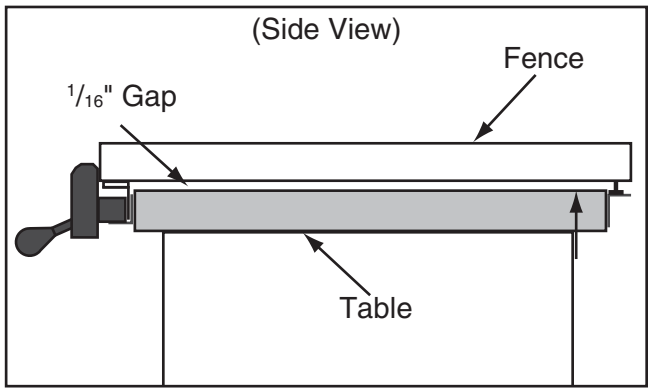


Figure 101. Gap between fence and table approximately 1/16" from from to back.

5. Adjust the fence height with the rear rail foot until the gap between the table and the fence is approximately 1/16" and even from the front of the table to the back.

Note: *If the front end of the fence needs to be adjusted up or down, use the set screws from **Figure 100**; however, turn them in even increments and recheck the squareness afterwards.*

Clamping Pressure and Parallelism

The fence clamping mechanism adjusts the clamping pressure to hold your fence securely and to position the fence parallel with the blade.

To adjust the fence clamping pressure and parallelism to the blade:

1. DISCONNECT THE SAW FROM POWER!

2. Remove the fence and adjust the set screws shown in **Figure 102** equally on the rear side of the front bracket as necessary until the clamping pressure is strong enough that the fence will not move as pressure is applied against it.

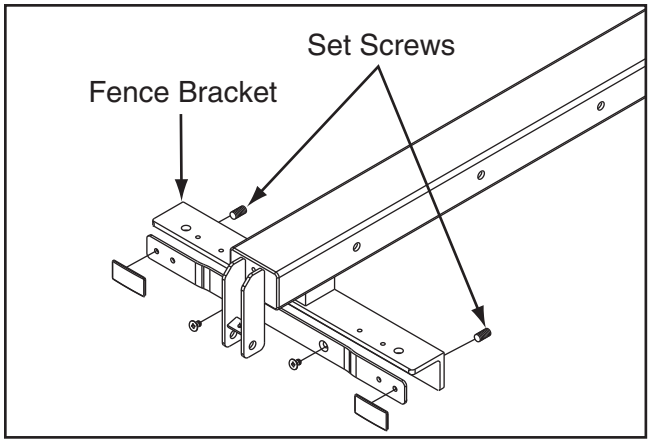


Figure 102. Location of set screws used to adjust fence parallelism and clamping pressure.

3. Mount the fence on the rail again, move it approximately 4" away from the blade, and lock it in place.

4. Measure the distance between the fence and the front of the blade, then mark the tooth that you measured from with a felt-tipped marker.

5. Rotate the blade 180° (**Figure 103**), and recheck the distance between the fence and the blade tooth you marked in **Step 4** to ensure they are parallel.

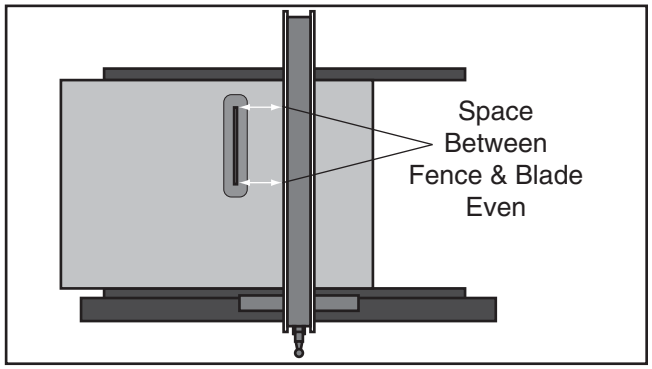


Figure 103. Example of fence aligned parallel with miter slot.

6. Use trial-and-error to adjust the set screws so the fence is parallel with the blade and the clamping pressure is sufficient.

   Optional: Some woodworkers prefer to offset the rear of the fence 1/64" from the blade, as shown in **Figure 104**, to help prevent the workpiece from binding and burning.

   The argument is that this offset adjustment reduces the chance of kickback by alleviating potential binding that may occur between the backside of the blade and fence. The trade-off is slightly less accurate cuts.

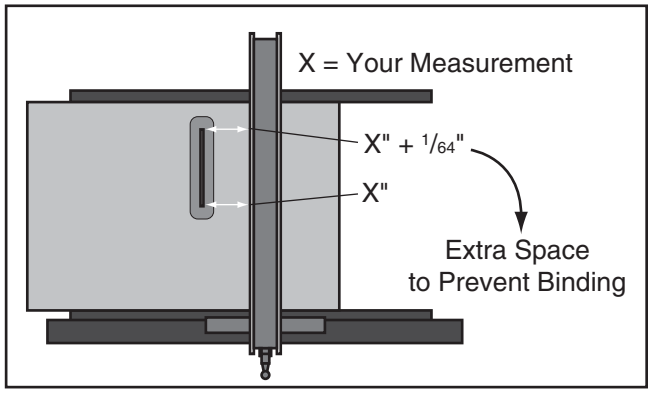


Figure 104. Adjusting fence with a 1/64" offset.

Fence Scale Calibration

The fence scale indicator windows, shown in **Figure 105**, can be calibrated with the fence scale if you notice that your cuts are not accurate. The indicator window on the right side is used when the fence is positioned on the right side of the blade. The indicator window on the left side is used when the fence is positioned on the left side of the blade.

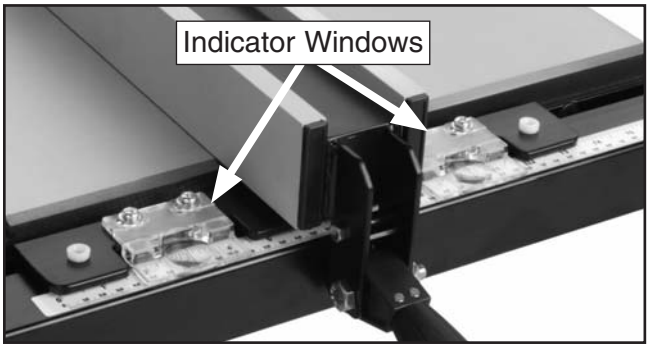


Figure 105. Example of fence indicator windows.

The indicator adjusts by loosening the two mounting screws and sliding it in the desired direction. Repeat this procedure for both windows.

Tools Needed	**Qty**
Phillips Head Screwdriver	1
Scrap Piece of Wood	1

To calibrate the fence scale indicator windows:

1. Position and lock the fence at 13", as indicated by the scale, then cut your scrap piece of wood.

2. Reposition and lock the fence at 12", as indicated by the scale.

3. Flip your scrap piece of wood over, placing the side that was cut in **Step 2** against the fence, then make your cut.

4. Measure the width of the freshly cut workpiece with a tape measure. The workpiece width should be exactly 12". If it is not, then adjust the indicator window to match the width of the workpiece.

Miter Gauge Adjustments

The miter gauge is equipped with stop screws that allow you to easily adjust the miter gauge from 45° to the left, 90°, and 45° to the right (see **Figure 106**). The stop screws contact the shaft, which moves in or out of the way for adjustments.

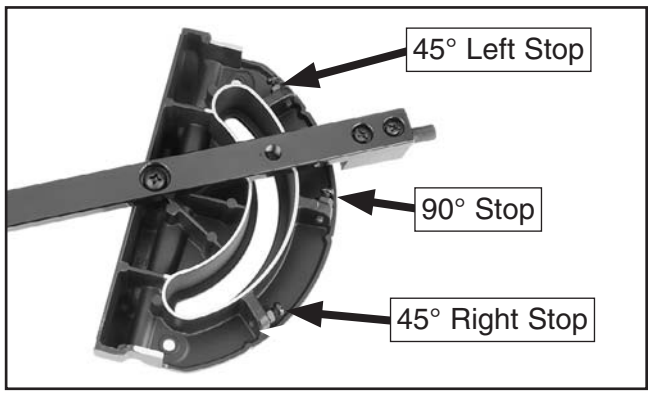


Figure 106. Miter gauge stops.

Tools Needed	Qty
Hex Wrench 2.5mm	1
Phillips Head Screwdriver	1
90° Square	1
45° Square	1
Wrench 8mm	1

Checking/Setting 90° Stops

1. DISCONNECT THE SAW FROM POWER!

2. Slide the miter gauge into the T-slot on the table.

3. Adjust the miter gauge so the 90° stop screw rests against the sliding shaft.

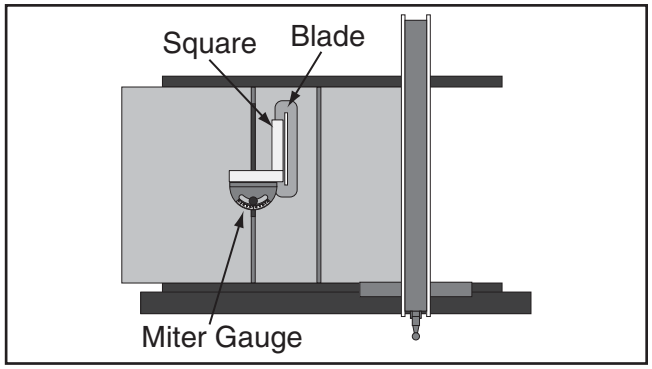


Figure 107. Checking 90° stop on miter gauge.

4. Place the 90° square evenly against the face of the miter gauge and the blade, as shown in **Figure 107**.

   —If the square touches the miter body and the body of the blade (not the teeth) evenly at the same time, then it is square to the blade and the 90° stop is set correctly. No further adjustments are necessary.

   —If the square does not touch the miter body and blade body evenly at the same time, then proceed to **Step 5**.

5. Loosen the hex nut (jam nut) that secures the 90° stop screw and adjust the stop screw until it is seated against the shaft while the square is evenly touching the miter body and the blade body, then tighten the hex nut.

6. Loosen the screw on the front of the miter bar, adjust the pointer to 0°, then tighten the screw.

Checking/Setting 45° Stops

Follow the same process with the 45° stops that you followed with the 90°, except using a 45° square or adjustable square to verify that the miter body is 45° to the blade, as shown in **Figure 108**.

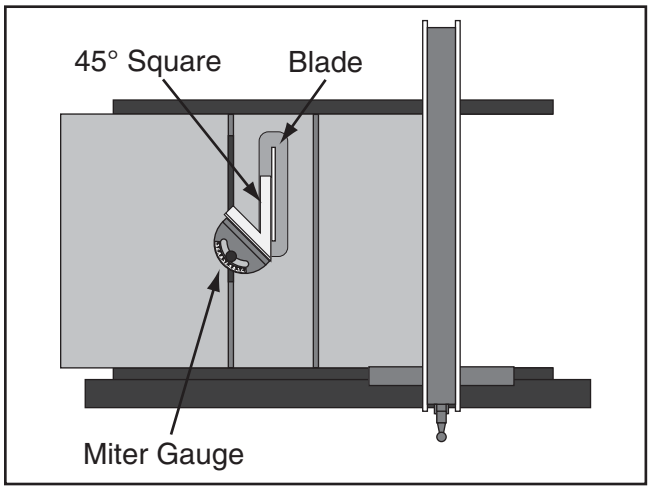


Figure 108. Checking 45° stop on miter gauge.

Table Tilt Handwheel Backlash

The table tilt handwheel should move with very little backlash or slop when the saw is new. However, over time the rack and pinion gears controlling the tilt handwheel will wear from use, causing backlash to increase. You can eliminate freeplay by adjusting the tilt handwheel gears.

Tools Needed	Qty
Hex Wrench 6mm	1
Wrench 12mm	1
Wrench 13mm	1

To adjust the table tilt gear backlash:

1. DISCONNECT THE SAW FROM POWER!

2. Turn the table tilt handwheel one way a couple turns, then turn it the other way to feel the backlash.

3. Unscrew the tap screws securing the angle sensor cover, then remove it to expose the rear rack mounting cap screw.

4. Loosen the two rack mounting cap screws and the jam nut shown in **Figure 109**.

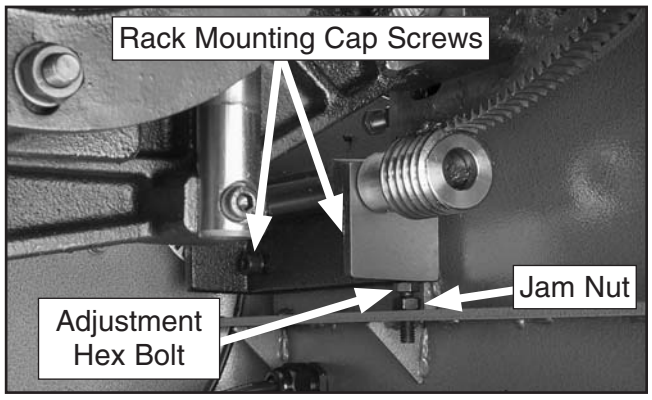


Figure 109. Table tilt handwheel adjustment.

5. While a helper tightens the adjustment hex bolt, turn the tilt handwheel back and forth. Tighten the hex bolt until you no longer feel any wobble or looseness when the handwheel is initially turned. Do not overtighten the rack-and-pinion gears or they will bind.

6. Tighten the jam nut and the rack mounting screws, reinstall the angle sensor cover, then close the motor access cover.

Digital Readout Calibration

The digital readout displays the current blade angle. Only set the readout after verifying that the 90° and 45° blade tilt stops are correctly positioned.

To calibrate the digital readout:

1. Ensure the power is connected and the 45° and 90° stop bolts are set (see **Blade Tilt Stops** starting on **Page 53**).

2. Move the blade angle to 90° and press the 0° SET button (**Figure 110**) for several seconds until the readout displays 0.00, or move the blade angle to 45° and press the 45° SET button until the readout displays 45.0.

   Note: *If you move the blade angle handwheel when the power is disconnected, the digital readout will display at 0.00 when the saw is reconnected, and you will need to reset it by following **Steps 1–2** above.*

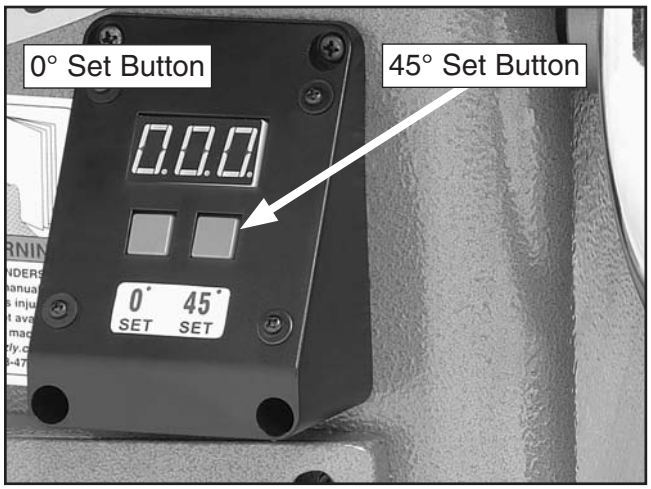


Figure 110. Digital readout.

Flat Belt Tension & Replacement

The flat belt stretches slightly as the saw is used. Most of the belt stretching will happen during the first 16 hours of use, but it may continue in small increments through continued use.

To ensure optimum power transmission from the motor to the blade, the flat belt must be in good condition. Replace the belt if it becomes cracked, frayed, or glazed.

Tools Needed	Qty
Arbor Wrenches	2
Wood Block 10" Long 4x4	1
Wrench or Socket 17mm	1
Wood Block 8" 2x6	1

Tensioning Flat Belt

1. DISCONNECT THE SAW FROM POWER!

2. Use the blade height handwheel to lower the motor all the way down.

3. Loosen the four motor mounting hex nuts shown in **Figure 111** two turns, then place the 4x4 wood block on top of the motor.

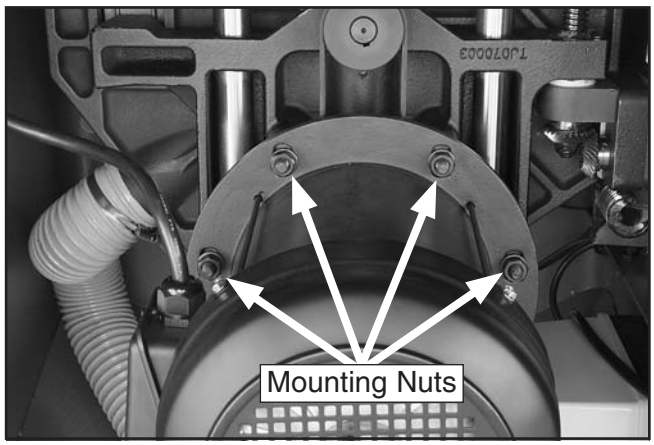


Figure 111. Motor mounting nuts.

4. Raise the motor to tension the belt, ensuring that the wood block is between the motor and cabinet, as shown in **Figure 112**.

   Note: *Be careful not to damage the motor, and do not force it up further when it becomes difficult to move the handwheel.*

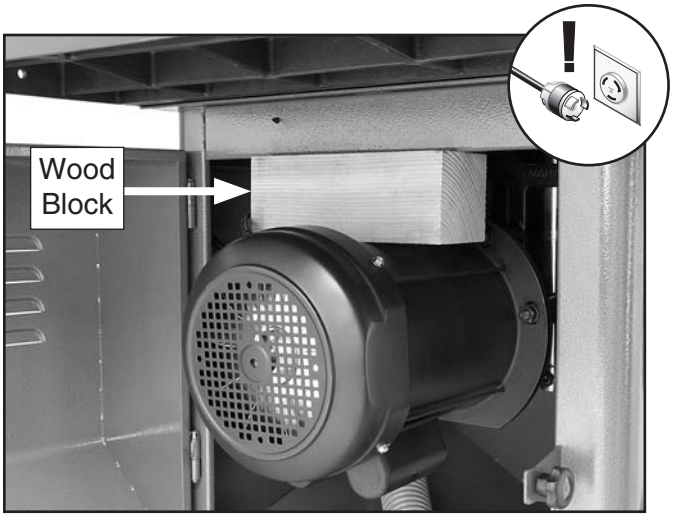


Figure 112. Example of using wood block to tension belt.

5. Press the flat belt in the the center to check belt tension. The belt is correctly tensioned when there is approximately ⅛" deflection when it is pushed with moderate pressure, as shown in **Figure 113**.

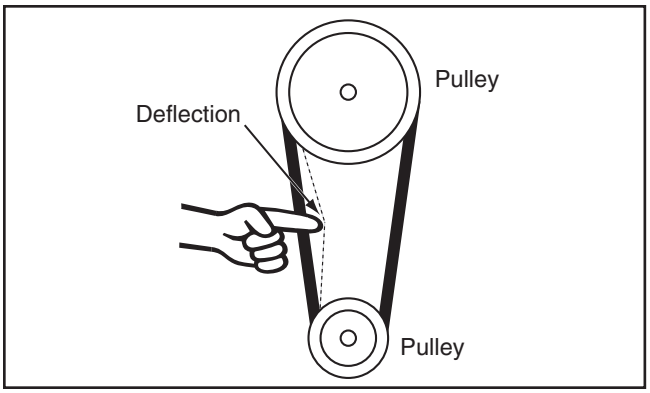


Figure 113. Checking belt deflection.

   —If there is more than ⅛" deflection when the flat belt is pushed with moderate pressure, raise the motor upward.

NOTICE

Do not overtighten the flat belt. If you do, it could decrease the lifespan of the motor and arbor bearings.

6. Tighten the motor mounting hex nuts, lower the motor, and remove the wood block.

7. Close the motor cover.

Replacing Flat Belt

1. DISCONNECT THE SAW FROM POWER!

2. Raise the motor all the way up, tilt it to 0°, and open the motor cover.

3. Loosen the four motor mounting hex nuts (**Figure 111**) two turns, and place the 2x6 block between the cabinet and bottom of the motor, as shown in **Figure 114**.

   Note: *Do not lower the motor too far on the Model G0605X1/G0696X or the board may dent the capacitor covers.*

Figure 114. Motor resting on wood block.

4. Lower the arbor assembly until the motor rests on the wood block, as shown in **Figure 114**, to reduce tension on the flat belt.

   Note: *Be careful not to damage the motor, and do not force the arbor down further when it becomes difficult to move the handwheel.*

5. Tighten the motor mounting nuts to hold the motor in place.

6. Raise the motor all the way up and remove the wood block.

7. Roll the belt off of the upper and lower pulleys, as shown in **Figure 115**. Be careful not to pinch your fingers.

   Note: *To make belt removal easier, turn the belt sideways and slide it down and past the back of the motor pulley.*

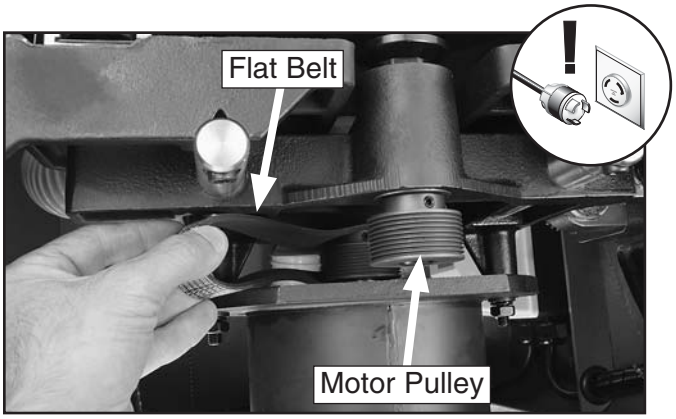


Figure 115. Removing flat belt (table removed for clarity).

8. Turn the new flat belt sideways and slip it over the motor pulley, so it engages one or two grooves (**Figure 116**).

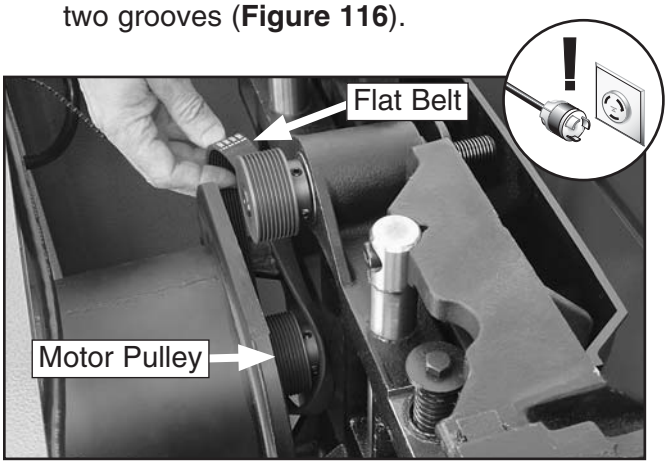


Figure 116. Installing flat belt.

9. Push the belt inward and roll it onto the top pulley. Continue pushing the belt and rotating it up and down (**Figure 117**) until it is centered on both pulleys.

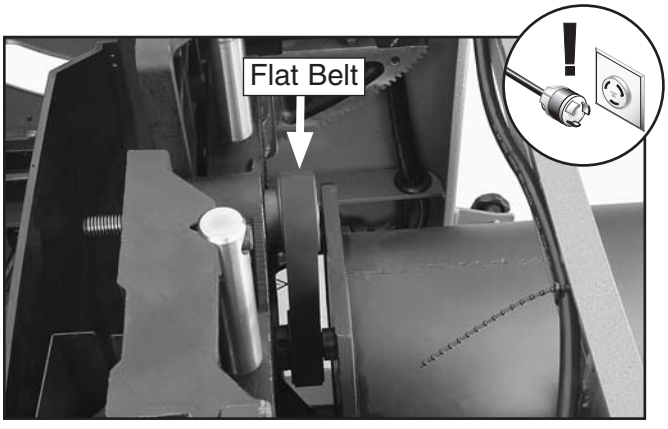


Figure 117. Flat belt installed.

10. Follow **Steps 2-7** in the ***Tensioning Flat Belt*** subsection to tension the flat belt.

SECTION 8: WIRING

These pages are current at the time of printing. However, in the spirit of improvement, we may make changes to the electrical systems of future machines. Study this section carefully. If there are differences between your machine and what is shown in this section, call Technical Support at (570) 546-9663 for assistance BEFORE making any changes to the wiring on your machine.

⚠WARNING
Wiring Safety Instructions

1. **SHOCK HAZARD.** Working on wiring that is connected to a power source is extremely dangerous. Touching electrified parts will result in personal injury including but not limited to severe burns, electrocution, or death. Disconnect the power from the machine before servicing electrical components!

2. **QUALIFIED ELECTRICIAN.** Due to the inherent hazards of electricity, only a qualified electrician should perform wiring tasks on this machine. If you are not a qualified electrician, get help from one before attempting any kind of wiring job.

3. **WIRE CONNECTIONS.** All connections must be tight to prevent wires from loosening during machine operation. Double-check all wires disconnected or connected during any wiring task to ensure tight connections.

4. **WIRE/COMPONENT DAMAGE.** Damaged wires or components increase the risk of serious personal injury, fire, or machine damage. If you notice that any wires or components are damaged while performing a wiring task, replace those wires or components before completing the task.

5. **MODIFICATIONS.** Using aftermarket parts or modifying the wiring beyond what is shown in the diagram may lead to unpredictable results, including serious injury or fire.

6. **MOTOR WIRING.** The motor wiring shown in these diagrams is current at the time of printing, but it may not match your machine. Always use the wiring diagram inside the motor junction box.

7. **CAPACITORS.** Some capacitors store an electrical charge for up to five minutes after being disconnected from the power source. To avoid being shocked, wait at least this long before working on capacitors.

8. **CIRCUIT REQUIREMENTS.** You MUST follow the requirements on **Page 10** when connecting your machine to a power source.

9. **EXPERIENCING DIFFICULTIES.** If you are experiencing difficulties understanding the information included in this section, contact our Technical Support at (570) 546-9663.

NOTICE

The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

BLACK	Bk	BLUE	Bl	YELLOW	Yl	LIGHT BLUE	Lb
WHITE	Wt	BROWN	Br	YELLOW GREEN	Yg	BLUE WHITE	Bw
GREEN	Gn	GRAY	Gy	PURPLE	Pu	TURQUOISE	Tu
RED	Rd	ORANGE	Or	PINK	Pk		

Common Electrical Components

Figure 118. G0605X1/G0696X motor junction box.

Figure 119. On/Off switch.

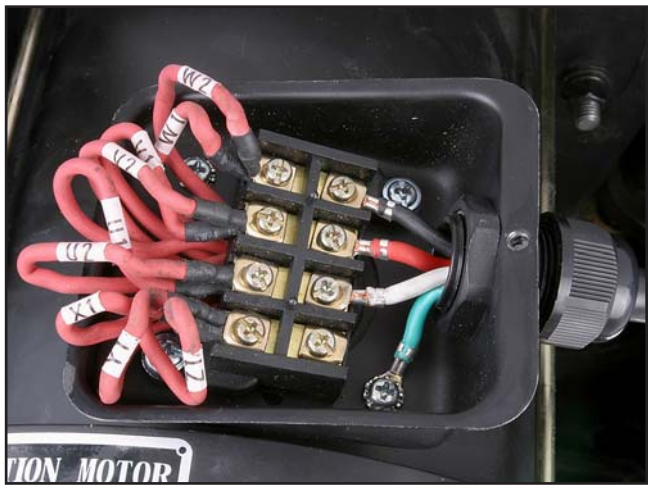


Figure 120. G0606X1/G0697X motor junction box.

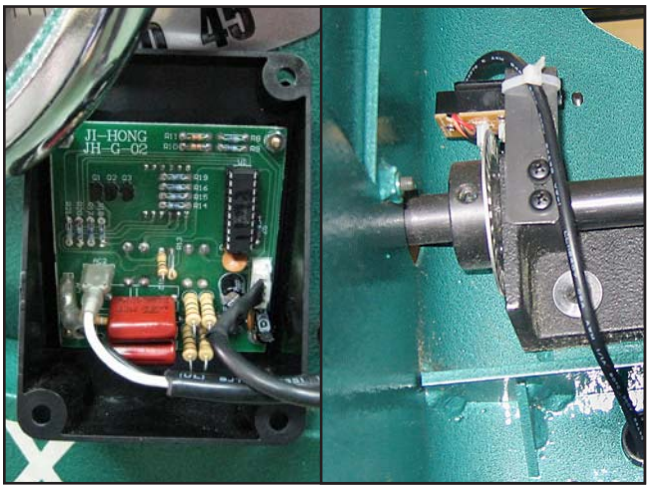


Figure 121. Digital readout and angle sensor.

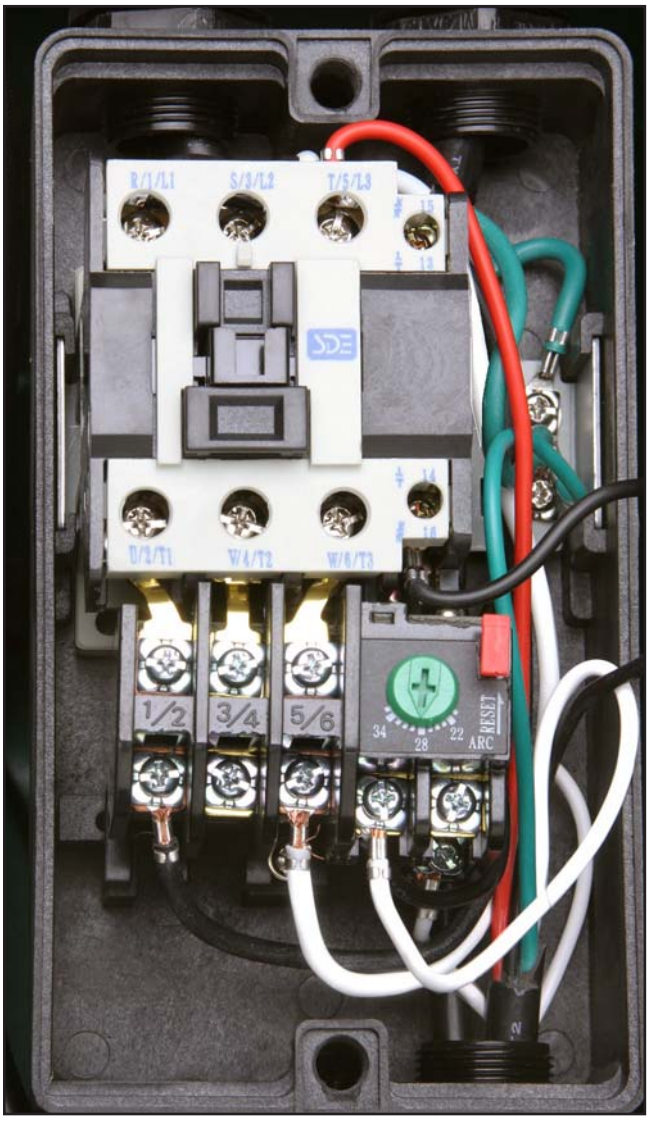


Figure 122. G0605X1/G0696X magnetic switch.

READ ELECTRICAL SAFETY ON PAGE 65!

G0605X1/G0696X Wiring 220V, 1-Ph

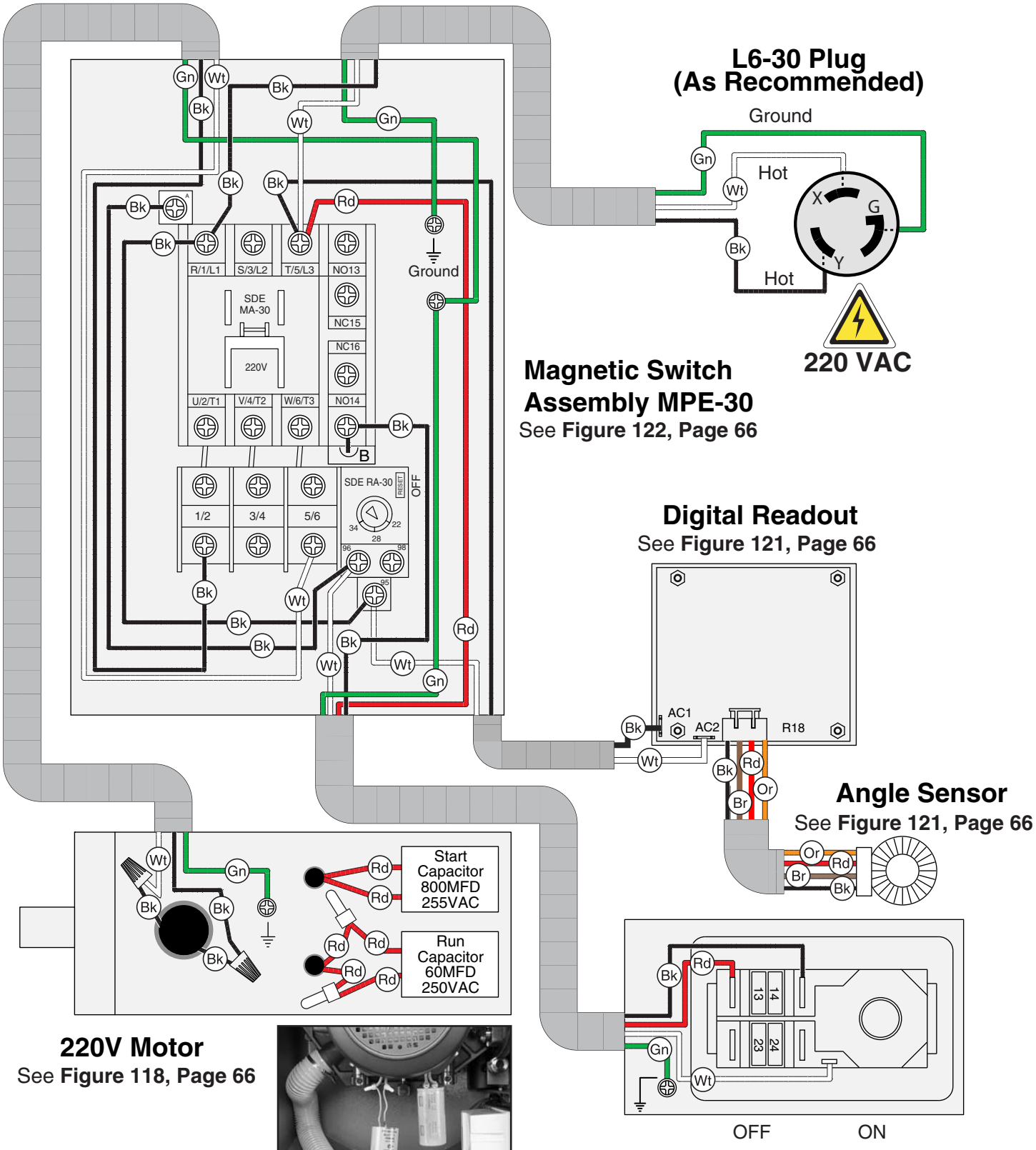


Figure 123. G0605X1/ G0696X capacitors.

G0606X1/G0697X Electrical Components

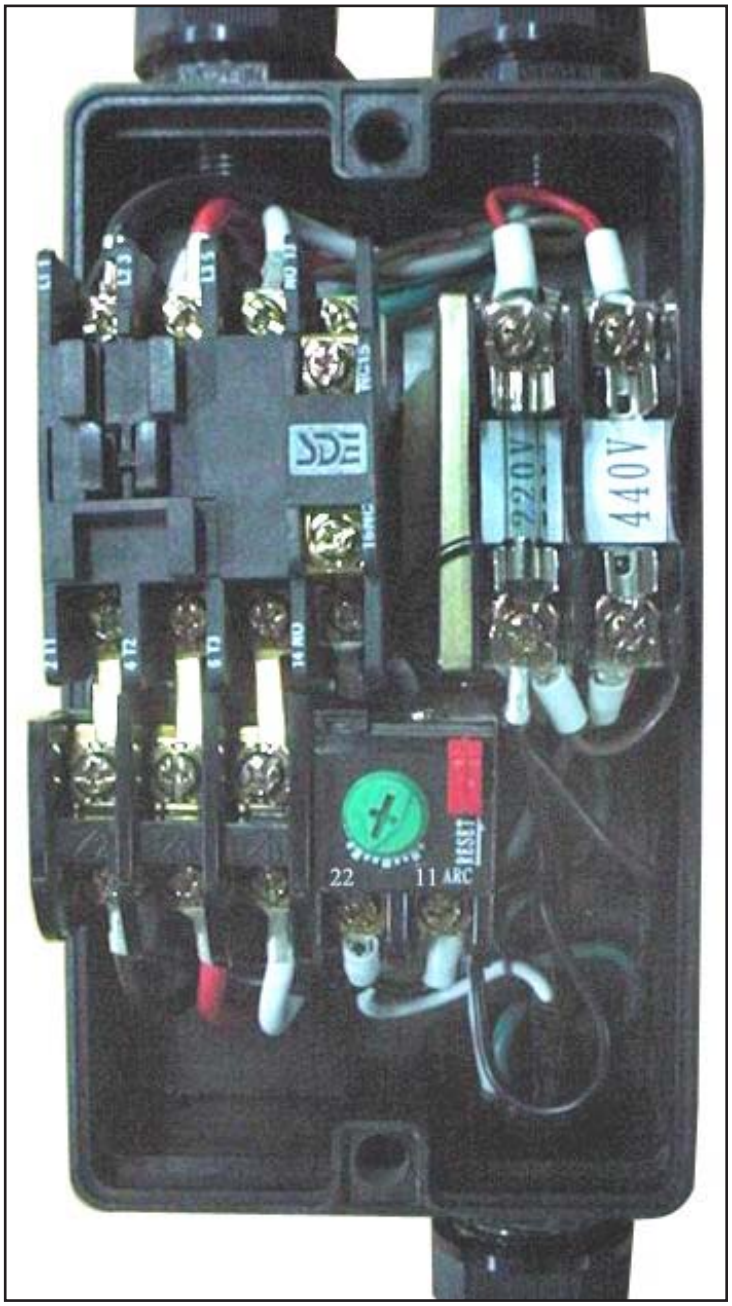


Figure 124. G0606X1/G0697X magnetic switch prewired to 220V, 3-phase.

Note: *The thermal relay in* ***Figure 124*** *is set for 20 amp, 220V, 3-phase operation.*

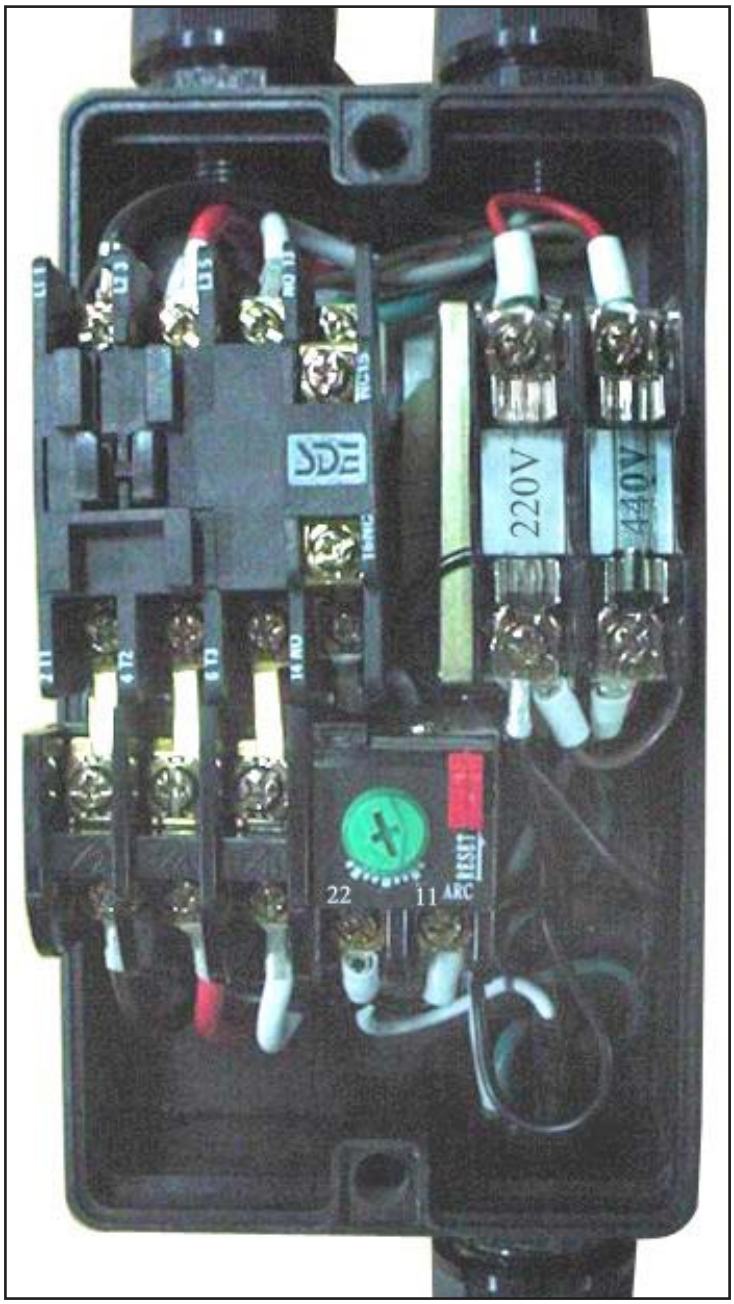
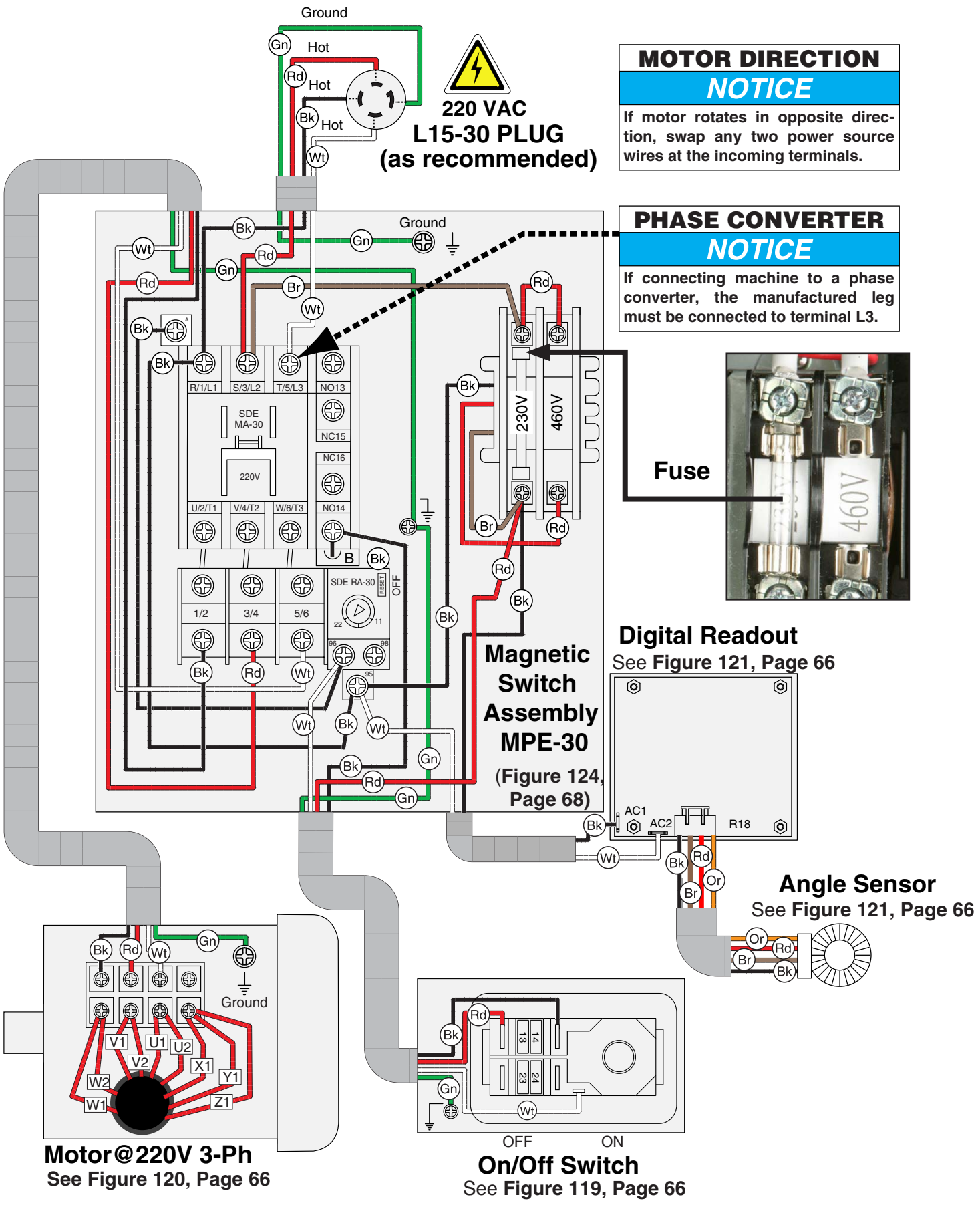


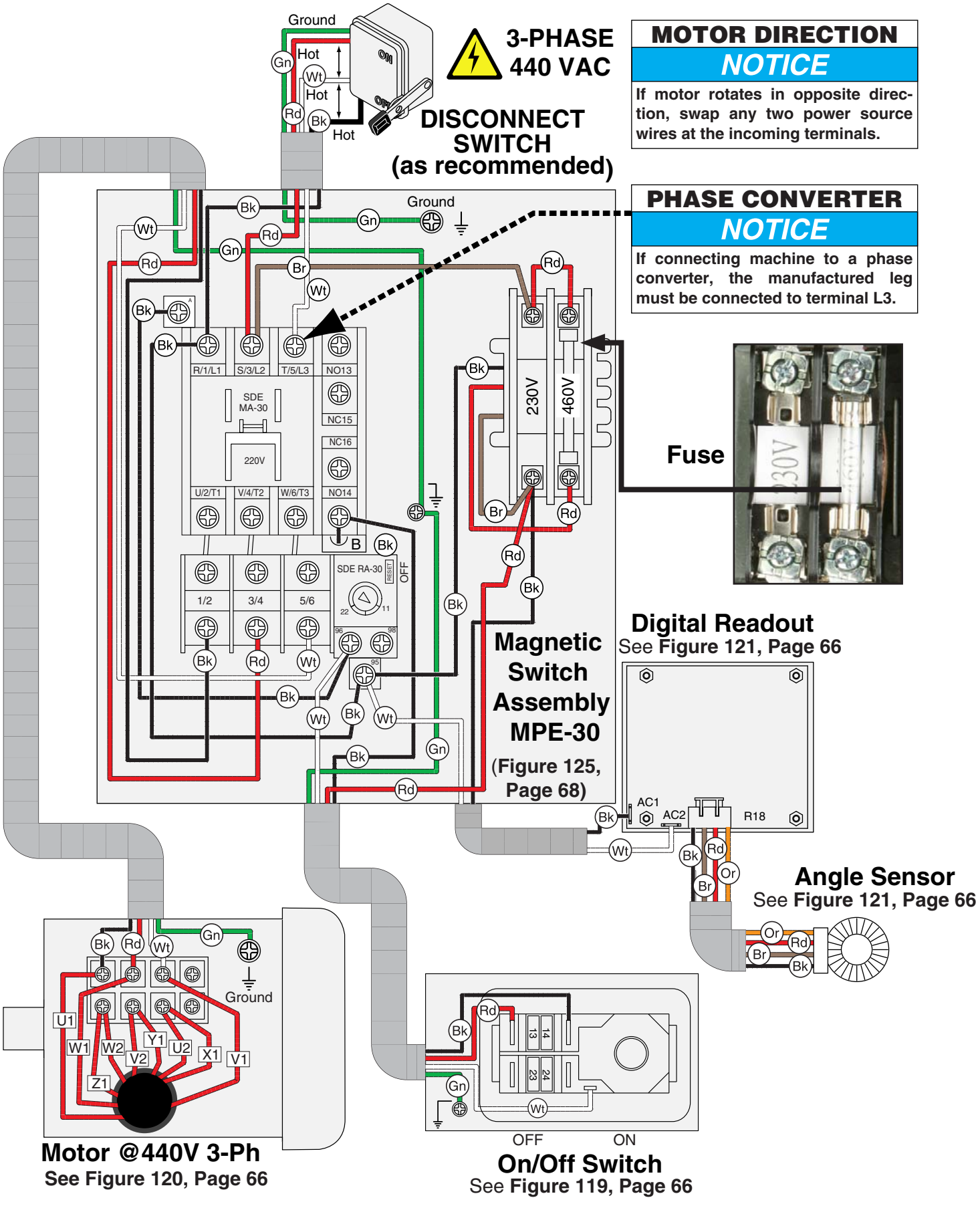
Figure 125. G0606X1/G0697X magnetic switch converted to 440V, 3-phase.

Note: *The therrmal relay in* ***Figure 125*** *is adjusted for 10 amp, 440V, 3-phase operation.*

G0606X1/G0697X Wiring 220V, 3-Ph



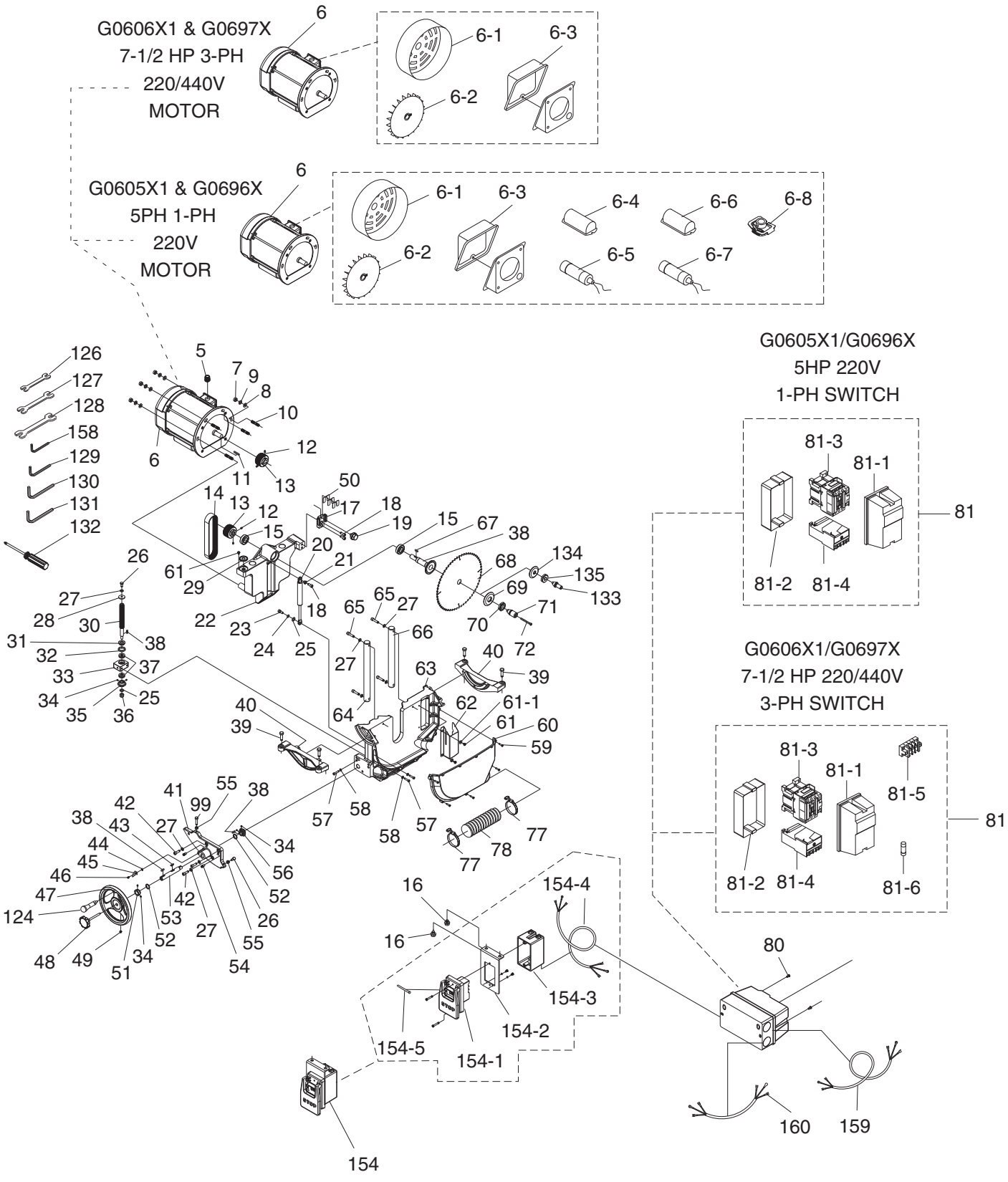
G0606X1/G0697X Wiring 440V, 3-Ph



READ ELECTRICAL SAFETY ON PAGE 65!

SECTION 9: PARTS

Motor and Arbor



Motor and Arbor Parts List

REF	PART #	DESCRIPTION
5	P0605X137	STRAIN RELIEF
7	PN02M	HEX NUT M10-1.5
8	PW04M	FLAT WASHER 10MM
9	PLW06M	LOCK WASHER 10MM
10	P0605X113	SPECIAL MOTOR BOLT
11	PK02M	KEY 5 X 5 X 40
12	PSS03M	SET SCREW M6-1 X 8
13	P0605X1013	MOTOR PULLEY
14	P0605X1014	FLAT BELT 220-J12
15	P6005	BALL BEARING 6005ZZ
16	PFB15M	FLANGE BOLT M8-1.25 X 12
17	P0605X1017	SPLITTER MOUNTING BRACKET
18	PSB14M	CAP SCREW M8-1.25 X 20
19	P0605X1019	MOUNTING BOLT
20	P0605X1020	STRUT
21	P0605X1021	BUSHING
22	P0605X1022	BRACKET
23	P0605X1023	SPECIAL SCREW
24	P0605X1024	WAVE WASHER 10MM
25	PW04M	FLAT WASHER 10MM
26	PB09M	HEX BOLT M8-1.25 X 20
27	PLW04M	LOCK WASHER 8MM
28	PW01M	FLAT WASHER 8MM
29	P0605X1029	BRUSH
30	P0605X1030	LEADSCREW
31	P0605X1031	BUSHING
32	P0605X1032	GASKET
33	P0605X1033	LEAD SCREW BRACKET
34	PSS07M	SET SCREW M5-.8 X 5
35	P0605X1035	BEVEL GEAR (L)
36	PLN10M	LOCK NUT M10-1.25
37	P51102	THRUST BEARING 51102
38	PK14M	KEY 5 X 5 X 18
39	PB14M	HEX BOLT M10-1.5 X 35
40	P0605X1040	TRUNNION SLIDE
41	P0605X1041	PLATE
42	PSB31M	CAP SCREW M8-1.25 X 25
43	P0605X1043	WOODRUFF KEY 22 X 5
44	PTLW05M	EXT TOOTH WASHER 6MM
45	P0605X021	TILT ARROW POINTER
46	PS14M	PHLP HD SCR M6-1 X 12
47	P0605X1047	HANDWHEEL
48	P0605X014	HANDWHEEL LOCK KNOB
49	PSS17	SET SCREW 5/16-18 X 5/16
50	P0605X1050	SHIM
51	P0605X1051	LOCK COLLAR

REF	PART #	DESCRIPTION
52	P0605X1052	FLAT WASHER 19MM
53	P0605X1053	BLADE HEIGHT HANDWHEEL SHAFT
54	P0605X1054	ALIGNMENT PIN
55	PN03M	HEX NUT M8-1.25
56	P0605X1056	BEVEL GEAR (R)
57	PSB06M	CAP SCREW M6-1 X 25
58	PLW03M	LOCK WASHER 6MM
59	PS06M	PHLP HD SCR M5-.8 X 20
60	P0605X1060	BLADE COVER
61	PS09M	PHLP HD SCR M5-.8 X 10
61-1	PW02M	FLAT WASHER 5MM
62	P0605X1062	DUST CHUTE
63	P0605X1063	TRUNNION
64	P0605X1064	FRONT COLUMN
65	PSB12M	CAP SCREW M8-1.25 X 40
66	P0605X1066	REAR COLUMN
67	P0605X1067	SHAFT
68	P0605X1068	BLADE
69	P0605X1069	ARBOR FLANGE
70	P0605X1070	ARBOR NUT 1"-10
71	P0605X1071	ARBOR EXTENSION 1"-10
72	PSB49M	CAP SCREW M6-1 X 60
77	P0605X1077	HOSE CLAMP 60MM DIA-80MM
78	P0605X066	DUST CHUTE HOSE 63 X 1000
80	P0605X1080	NYLON SCREW #10-24 X 1/2
99	PB20M	HEX BOLT M8-1.25 X 35
124	P0605X1124	HANDWHEEL HANDLE
126	PWR810	WRENCH 8 X 10
127	PWR1113	WRENCH 11 X 13
128	PWR1417	WRENCH 14 X 17
129	PAW04M	HEX WRENCH 4MM
130	PAW05M	HEX WRENCH 5MM
131	PAW06M	HEX WRENCH 6MM
132	P0605X1132	PHILLIPS/STANDARD SCREWDRIVER
133	P0605X1133	ARBOR EXTENSION 5⁄8"-12 x 1-1⁄4"
134	P0605X1134	ARBOR NUT 5/8"-12
135	P0605X1135	ARBOR FLANGE 5/8"
154	P0605X154	ON/OFF SWITCH ASSEMBLY
154-1	P0605X154-1	ON/OFF PUSH BUTTON SWITCH
154-2	P0605X154-2	ON/OFF SWITCH BRACKET
154-3	P0605X154-3	ON/OFF SWITCH BOX
154-4	P0605X154-4	ON/OFF SWICH CORD 14AWG X 3C
154-5	P0605X154-5	SAFETY PIN
158	PAW03M	HEX WRENCH 3MM
159	P0605X1159	MOTOR CORD 12AWG X 3C
160	P0605X1160	POWER CORD 12AWG X 3C

G0605X1/G0696X 5HP, 1-PH MOTOR

6	P0605X1006	MOTOR 5HP 220V 1-PH
6-1	P0605X1006-1	MOTOR FAN COVER
6-2	P0605X1006-2	MOTOR FAN
6-3	P0605X1006-3	WIRING JUNCTION BOX
6-4	P0605X1006-4	R CAPACITOR COVER
6-5	P0605X1006-5	R CAPACITOR 60M 250V 1-3/4 X 3-5/16
6-6	P0605X1006-6	S CAPACITOR COVER
6-7	P0605X1006-7	S CAPACITOR 800M 250V 1-3/4 X 3-3/4
6-8	P0605X1006-8	CENTRIFUGAL SWITCH

G0606X1/G0697X 7½HP, 3-PH MOTOR

6	P0606X1006	MOTOR 7-1/2 HP 220V/440V 3-PH
6-1	P0606X1006-1	MOTOR FAN COVER
6-2	P0606X1006-2	MOTOR FAN
6-3	P0606X1006-3	WIRING JUNCTION BOX

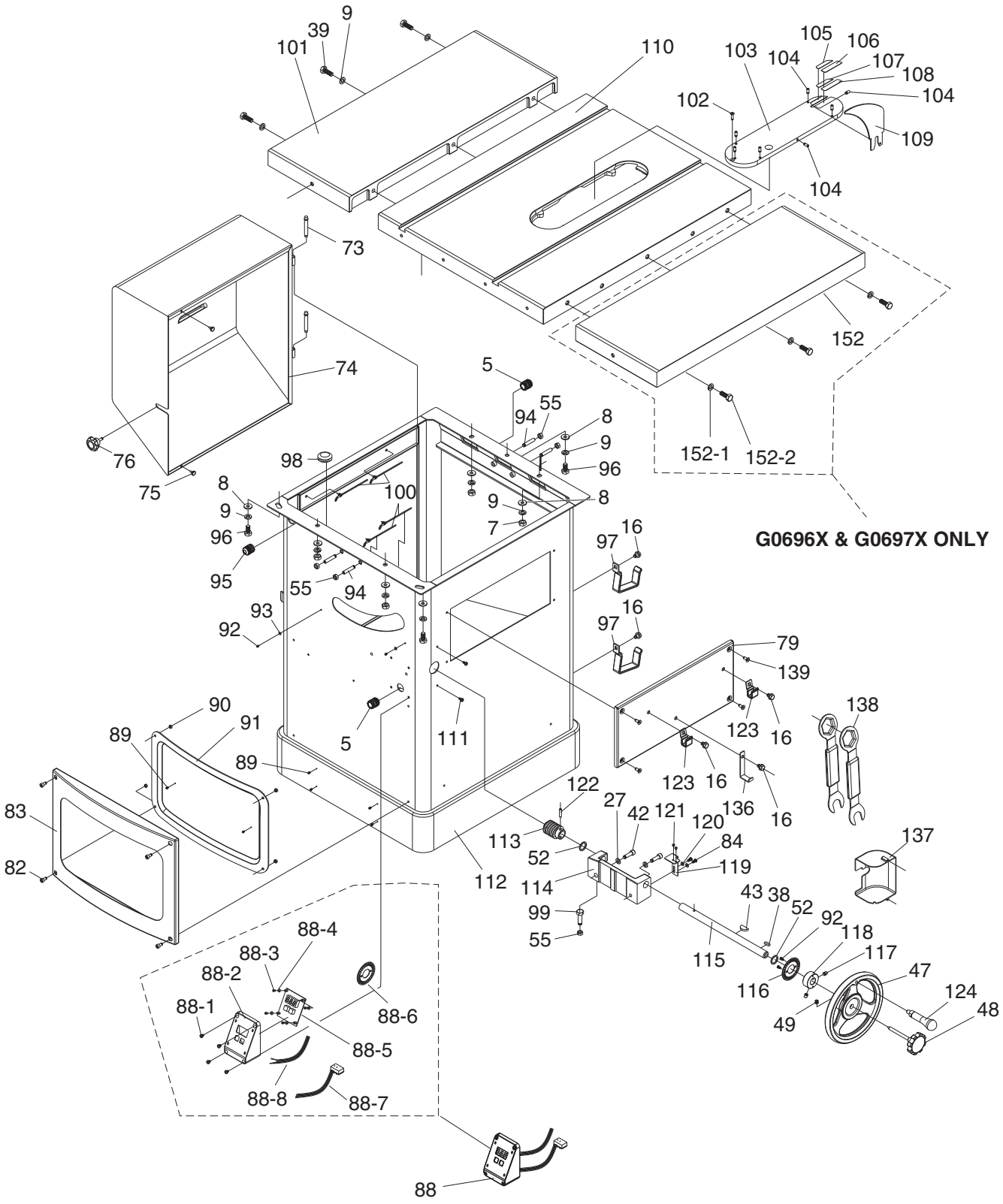
G0605X1/G0696X 5HP, 1-PH MAG SWITCH

81	P0605X075	MAG SWITCH ASSY MPE-30
81-1	P0605X075-1	MAG SWITCH FRONT COVER
81-2	P0605X075-2	MAG SWITCH BACK COVER
81-3	P0605X075-3	CONTACTOR SDE MA-30 220V
81-4	P0605X075-4	OL RELAY SDE RA-30 22~34

G0606X1/G0697X 7½HP, 3-PH MAG SWITCH

81	P0606X075	MAGNETIC SWITCH ASSY MPE-30
81-1	P0606X075-1	MAG SWITCH FRONT COVER
81-2	P0606X075-2	MAG SWITCH BACK COVER
81-3	P0606X075-3	CONTACTOR SDE MA-30 220V
81-4	P0606X075-4	OL RELAY SDE RA-30 11~22
81-5	P0606X075-7	TRANSFORMER
81-6	P0606X075-8	FUSE

Cabinet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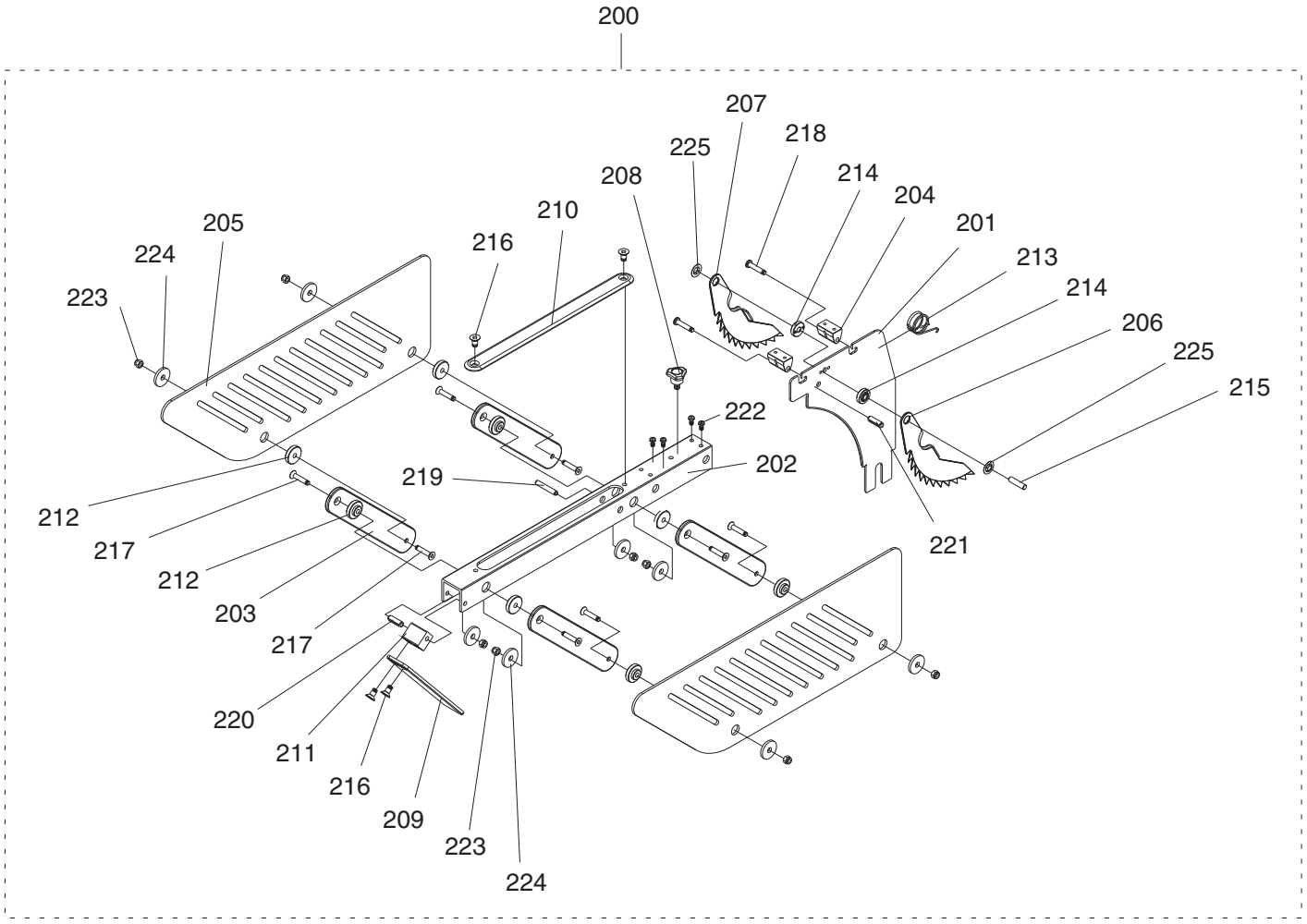
Cabinet Parts List

REF	PART #	DESCRIPTION
5	P0605X137	STRAIN RELIEF
7	PN02M	HEX NUT M10-1.5
8	PW04M	FLAT WASHER 10MM
9	PLW06M	LOCK WASHER 10MM
16	PFB15M	FLANGE BOLT M8-1.25 X 12
27	PLW04M	LOCK WASHER 8MM
38	PK14M	KEY 5 X 5 X 18
39	PB14M	HEX BOLT M10-1.5 X 35
42	PSB31M	CAP SCREW M8-1.25 X 25
43	P0605X1043	WOODRUFF KEY 22 X 5
47	P0605X1047	HANDWHEEL
48	P0605X014	HANDWHEEL LOCK KNOB
49	PSS17	SET SCREW 5/16-18 X 5/16
52	P0605X1052	FLAT WASHER 19MM
55	PN03M	HEX NUT M8-1.25
73	P0605X1073	ALIGNMENT PIN
74	P0605X073	MOTOR COVER
75	P0605X1075	RUBBER BUMPER
76	P0605X1076	LOCK KNOB M6-1 X 17
79	P0605X1079	RIGHT COVER
82	PSB26M	CAP SCREW M6-1 X 12
83	P0605X1083	COVER
84	PS05M	PHLP HD SCR M5-.8 X 8
88	P0651083	DIGITAL SENSOR ASSEMBLY
88-1	PS05M	PHLP HD SCR M5-.8 X 8
88-2	P0651083-2	DIGITAL READOUT COVER
88-3	PS79M	PHLP HD SCR M3-.5 X 8
88-4	PW07M	FLAT WASHER 3MM
88-5	P0651083-5	CIRCUIT BOARD
88-6	P0651083-6	SENSOR PLATE
88-7	P0651083-7	DATA CORD 24 AWG X 450
88-8	P0651083-8	DIGITAL READOUT CORD 18 AWG X 2C
89	PS79M	PHLP HD SCR M3-.5 X 8
90	PN06M	HEX NUT M5-.8
91	P0605X079	PLATE
92	PS17M	PHLP HD SCR M4-.7 X 6
93	PW05M	FLAT WASHER 4MM
94	PSS42M	SET SCREW M8-1.25 X 50

REF	PART #	DESCRIPTION
95	P0605X1095	STRAIN RELIEF PGA13.5-11B
96	PB32M	HEX BOLT M10-1.5 X 25
97	P0651097	FENCE RESTING BRACKET
98	P0605X1098	STRAIN RELIEF
99	PB20M	HEX BOLT M8-1.25 X 35
100	P0605X1100	CHAIN
101	P0605X116	EXTENSION WING (L)
102	PFH54M	FLAT HD SCR M5-.8 X 20
103	P0605X1103	TABLE INSERT
104	PSS04M	SET SCREW M6-1 X 12
105	P0605X1105	PLATE (L)
106	P0605X1106	PLATE (R)
107	P0605X1107	TAPE (L)
108	P0605X1108	TAPE (R)
109	P0605X1109	RIVING KNIFE
110	P0605X035	TABLE
111	PHTEK39M	TAP SCREW M4 X 12
112	P0605X1112	CABINET
113	P0605X1113	WORM GEAR
114	P0605X1114	BLADE TILT SHAFT BRACKET
115	P0605X1115	BLADE TILT SHAFT
116	P0651083-6	SENSOR PLATE
117	PSS16M	SET SCREW M8-1.25 X 10
118	P0605X1118	SPECIAL RING
119	P0651112	L-PLATE
120	PW02M	FLAT WASHER 5MM
121	PHTEK30M	TAP SCREW M3 X 6
122	PRP27M	ROLL PIN 5 X 28
123	P0651106	MITER GAUGE MOUNTING BRACKET
124	P0605X1124	HANDWHEEL HANDLE
136	P0651107	WRENCH MOUNTING BRACKET
137	P0651087	DUST COVER
138	P0651108	ARBOR WRENCH
139	PFH06M	FLAT HD SCR M6-1 X 20
152	P0696X152	EXTENSION WING
152-1	PLW06M	LOCK WASHER 10MM
152-2	PB14M	HEX BOLT M10-1.5 X 35

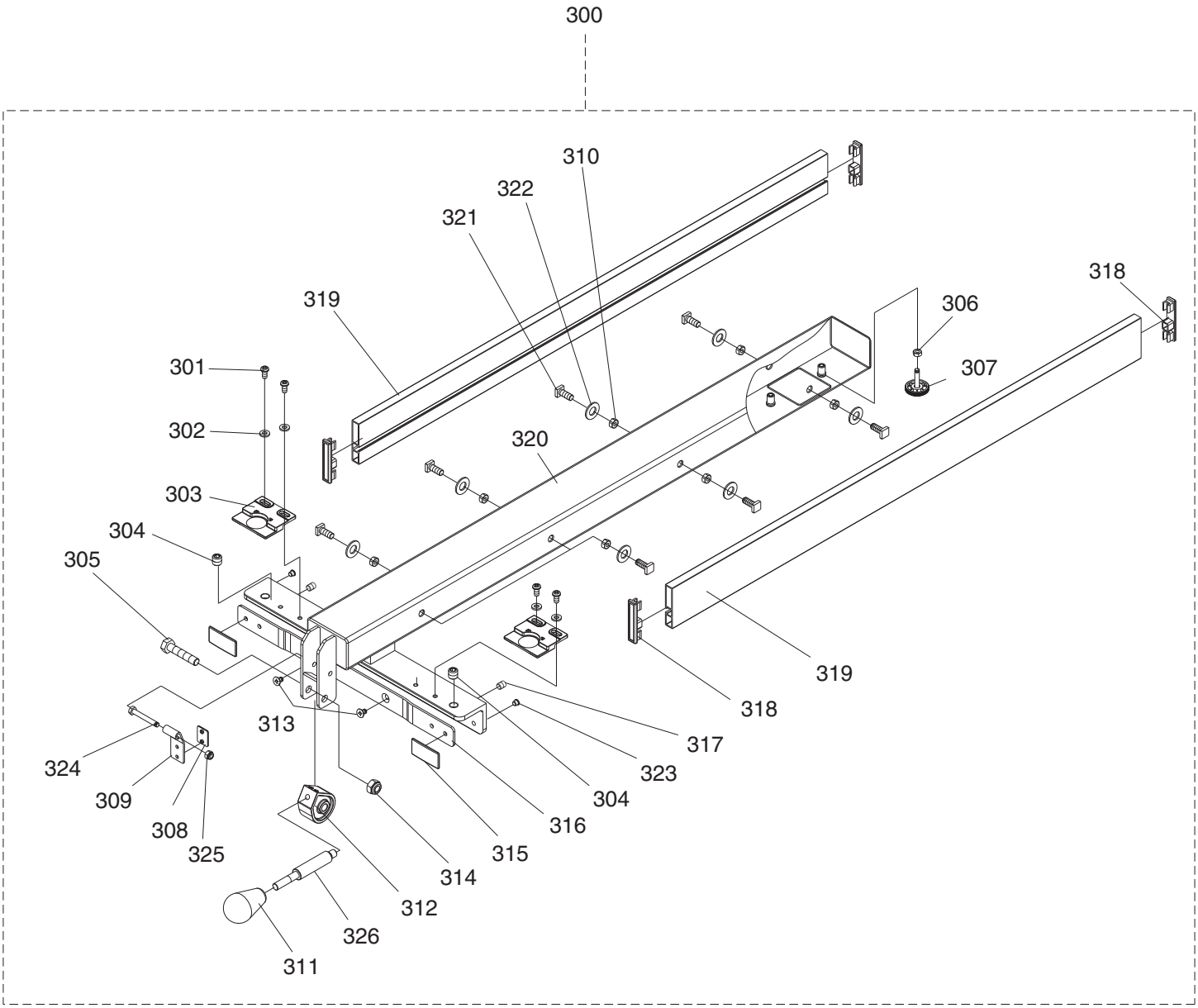
Blade Guard



REF	PART #	DESCRIPTION
200	P0605X200	BLADE GUARD ASSEMBLY
201	P0605X201	SPLITTER
202	P0605X202	SUPPORT
203	P0605X203	BLADE GUARD SWING BRACKET
204	P0605X204	BRACKET
205	P0605X205	BLADE GUARD COVER
206	P0605X206	RIGHT ANTI-BACK PAWL
207	P0605X207	LEFT ANTI-BACK PAWL
208	P0605X208	MITER GAUGE LOCK KNOB
209	P0605X209	FRONT COVER
210	P0605X210	UPPER COVER
211	P0605X211	BLOCK
212	P0605X212	SPACER

REF	PART #	DESCRIPTION
213	P0605X213	TORSION SPRING
214	P0605X214	RING 6MM
215	P0605X215	PIN 6 X 24
216	PFH43M	FLAT HD SCR M6-1 X 10
217	PFH54M	FLAT HD SCR M5-.8 X 20
218	PS22M	PHLP HD SCR M5-.8 X 25
219	PRP95M	ROLL PIN 8 X 55
220	PRP45M	ROLL PIN 5 X 32
221	PRP07M	ROLL PIN 6 X 20
222	PS07M	PHLP HD SCR M4-.7 X 8
223	PLN02M	LOCK NUT M5-.8
224	PW02M	FLAT WASHER 5MM
225	P0605X225	RING 6MM

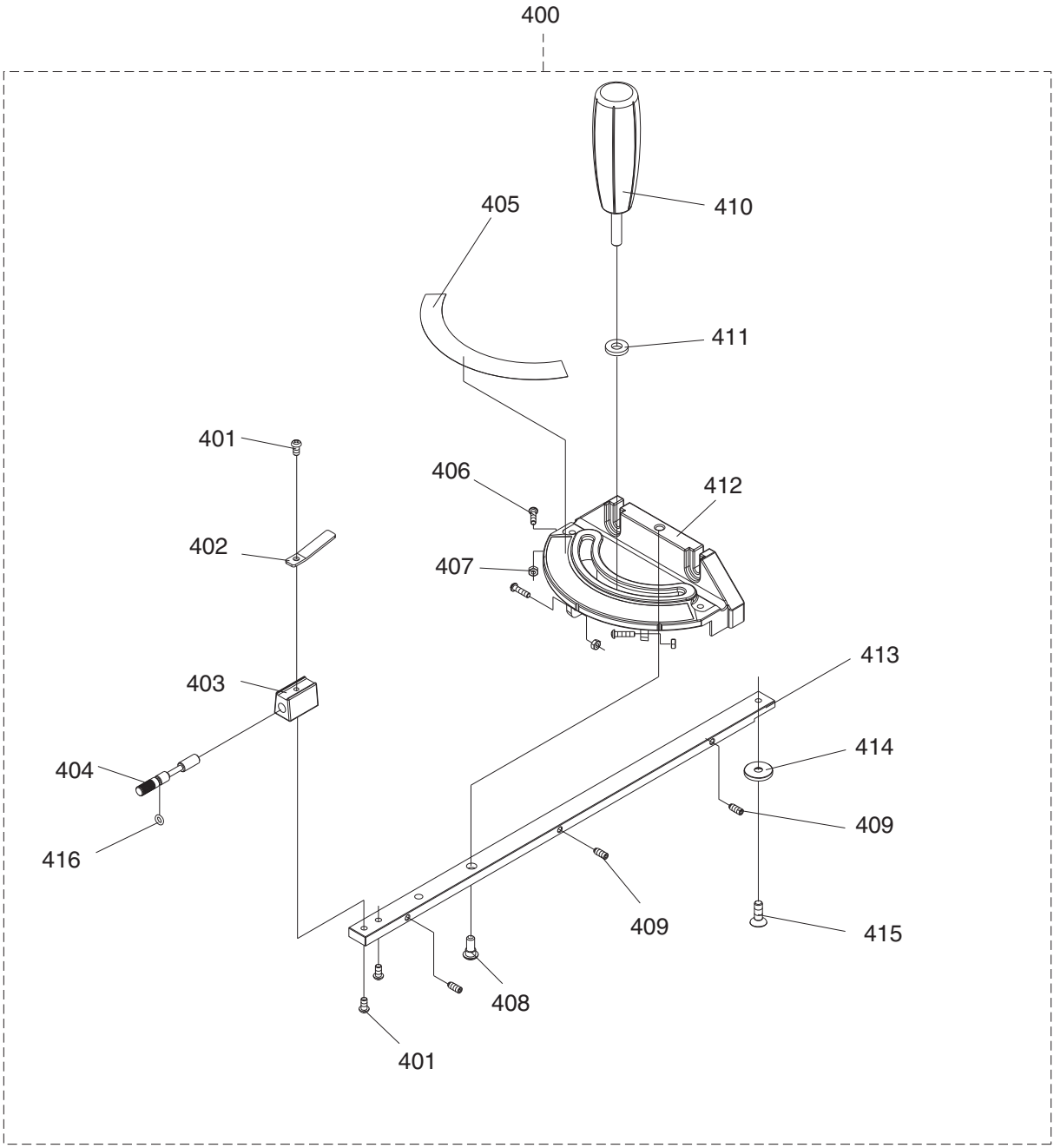
Fence



REF	PART #	DESCRIPTION
300	P0605X1300	FENCE ASSEMBLY
301	PS14M	PHLP HD SCR M6-1 X 12
302	PW03M	FLAT WASHER 6MM
303	P0605X303	POINTER
304	P0605X304	PLASTIC SET SCREW
305	PB73M	HEX BOLT M10-1.5 X 50
306	PN01M	HEX NUT M6-1
307	P0605X307	REAR RAIL WHEEL
308	P0605X1308	PLATE
309	P0605X1309	BRACKET
310	PN03M	HEX NUT M8-1.25
311	P0605X1311	FENCE HANDLE
312	P0605X1312	CAM ASSEMBLY
313	PFH43M	FLAT HD SCR M6-1 X 10

REF	PART #	DESCRIPTION
314	PLN05M	LOCK NUT M10-1.5
315	P0605X315	PLATE
316	P0605X316	CLAMPING BRACKET
317	PSS20M	SET SCREW M8-1.25 X 8
318	P0605X318	PLATE CAP
319	P0605X319	FENCE PLATE
320	P0605X320	FENCE
321	P0605X321	T-BOLT M8-1.25 X 20
322	PW01M	FLAT WASHER 8MM
323	P0605X1323	BLOCK
324	PB71M	HEX BOLT M6-1 X 45
325	PLN03M	LOCK NUT M6-1
326	P0605X1326	SHAFT

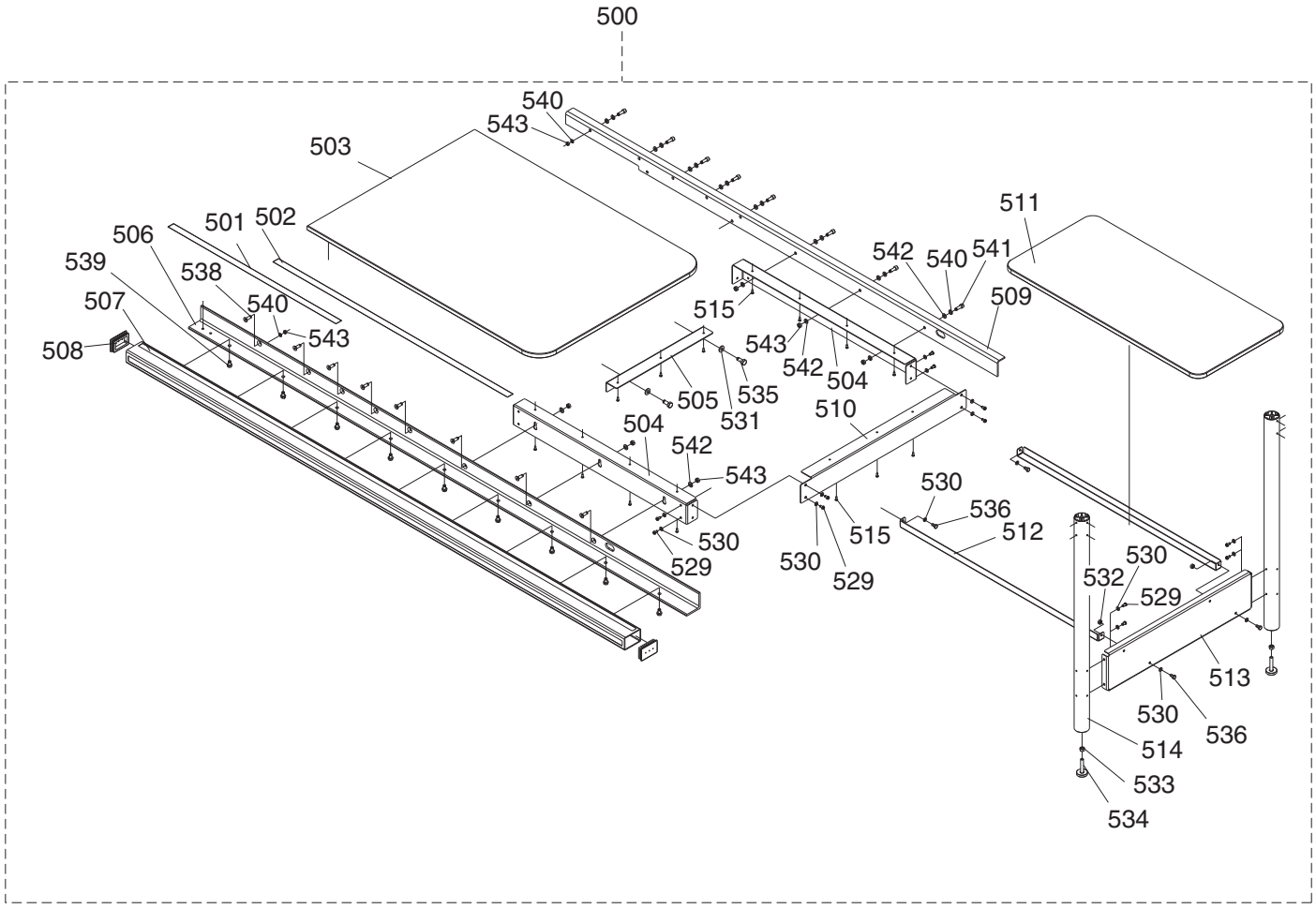
Miter Gauge



REF	PART #	DESCRIPTION
400	P0605X1400	MITER GAUGE
401	PS06	PHLP HD SCR 10-24 X 3/8
402	P0605X1402	POINTER
403	P0605X403	BLOCK
404	P0605X1404	SHAFT
405	P0605X405	MITER GAUGE LABEL
406	PS25	PHLP HD SCR 8-32 X 5/8
407	PN14	HEX NUT 8-32
408	P0605X1408	SPECIAL SCREW 1/4-20 X 1/2

REF	PART #	DESCRIPTION
409	P0605X1409	SET SCREW M5-.8 X 12
410	P0605X1410	MITER GAUGE HANDLE
411	PW01M	FLAT WASHER 8MM
412	P0605X412	MITER GAUGE
413	P0605X413	PLATE
414	P0605X414	GUIDE PLATE
415	PFH9M	FLAT HD SCR M6-1 X 6
416	PORP005	O-RING 4.8 X 1.9 P5

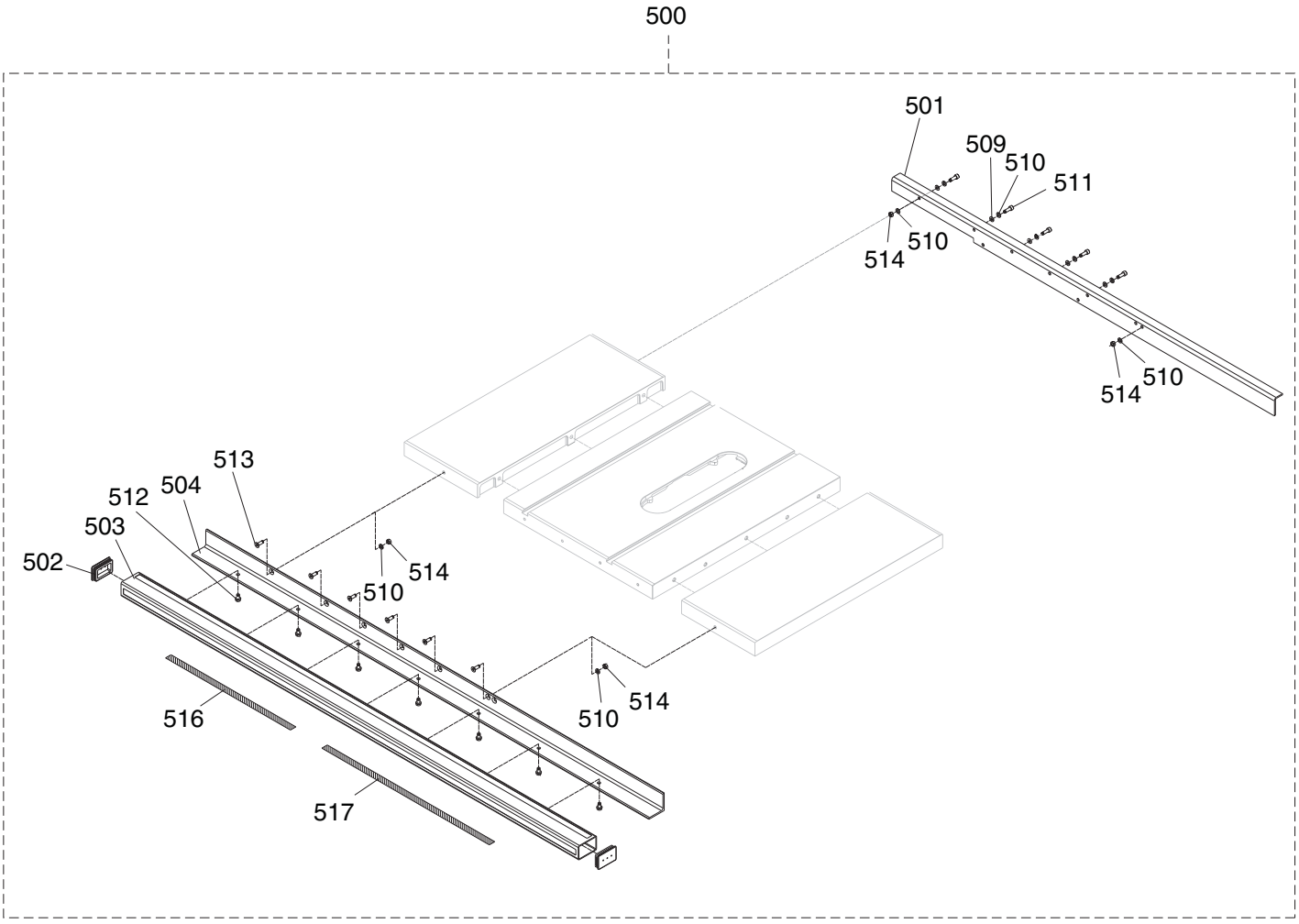
Extension Table (G0605X1/G0606X1)



REF	PART #	DESCRIPTION
500	P0605X1500	EXTENSION TABLE ASSEMBLY
501	P0605X1501	LEFT SCALE 18"
502	P0605X1502	RIGHT SCALE 52"
503	P0605X503	EXTENSION TABLE PLATE
504	P0605X504	EXTENSION TABLE SUPPORT
505	P0605X505	FRONT EXTENSION BRACKET
506	P0605X506	FRONT RAIL
507	P0605X507	FENCE TUBE
508	P0605X508	END CAP
509	P0605X509	REAR RAIL
510	P0605X510	REAR EXTENSION BRACKET
511	P0605X511	LOWER SHELF
512	P0605X512	LOWER SHELF BRACKET
513	P0605X513	SHELF END PLATE
514	P0605X514	SUPPORT LEG

REF	PART #	DESCRIPTION
515	PHTEK6M	TAP SCREW M4 X 16
529	PS14M	PHLP HD SCR M6-1 X 12
530	PW03M	FLAT WASHER 6MM
531	PW04M	FLAT WASHER 10MM
532	PN01M	HEX NUT M6-1
533	PN08	HEX NUT 3/8-16
534	P0605X534	FOOT 3/8-16 X 2
535	PB32M	HEX BOLT M10-1.5 X 25
536	PS14M	PHLP HD SCR M6-1 X 12
538	PFH21M	FLAT HD SCR M8-1.25 X 25
539	PFB15M	FLANGE BOLT M8-1.25 X 12
540	PLW04M	LOCK WASHER 8MM
541	PSB31M	CAP SCREW M8-1.25 X 25
542	PW01M	FLAT WASHER 8MM
543	PN03M	HEX NUT M8-1.25

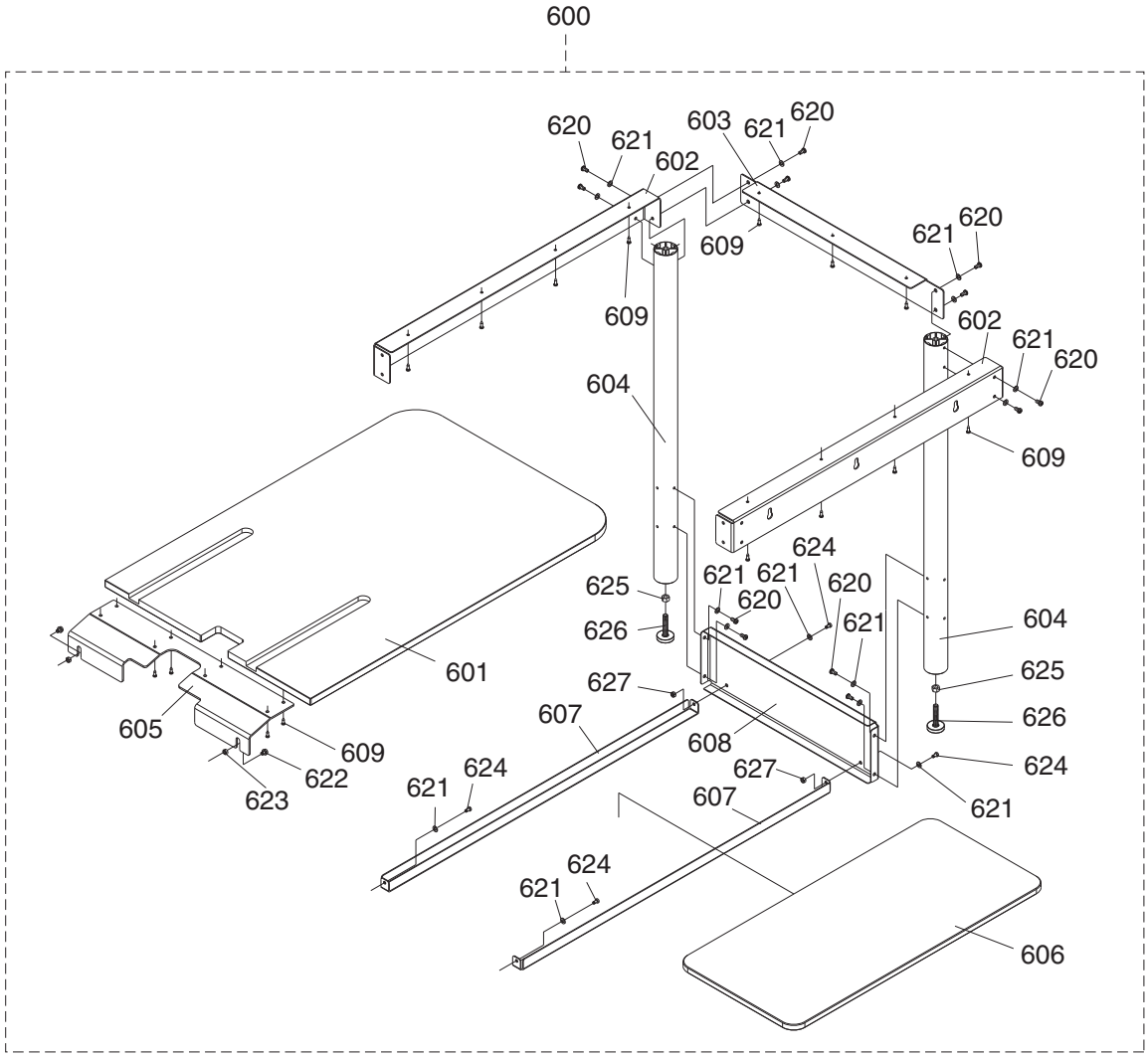
Rails (Model G0696X/G0697X)



REF	PART #	DESCRIPTION
500	P0696X500	RAIL ASSEMBLY
501	P0696X501	REAR RAIL
502	P0696X502	END CAP
503	P0696X503	FENCE TUBE
504	P0696X504	FRONT RAIL
509	PW01M	FLAT WASHER 8MM
510	PLW04M	LOCK WASHER 8MM

REF	PART #	DESCRIPTION
511	PSB31M	CAP SCREW M8-1.25 X 25
512	PFB15M	FLANGE BOLT M8-1.25 X 12
513	PB07M	HEX BOLT M8-1.25 X 25
514	PN03M	HEX NUT M8-1.25
516	P0605X1501	LEFT SCALE 18"
517	P0696X517	RIGHT SCALE 36"

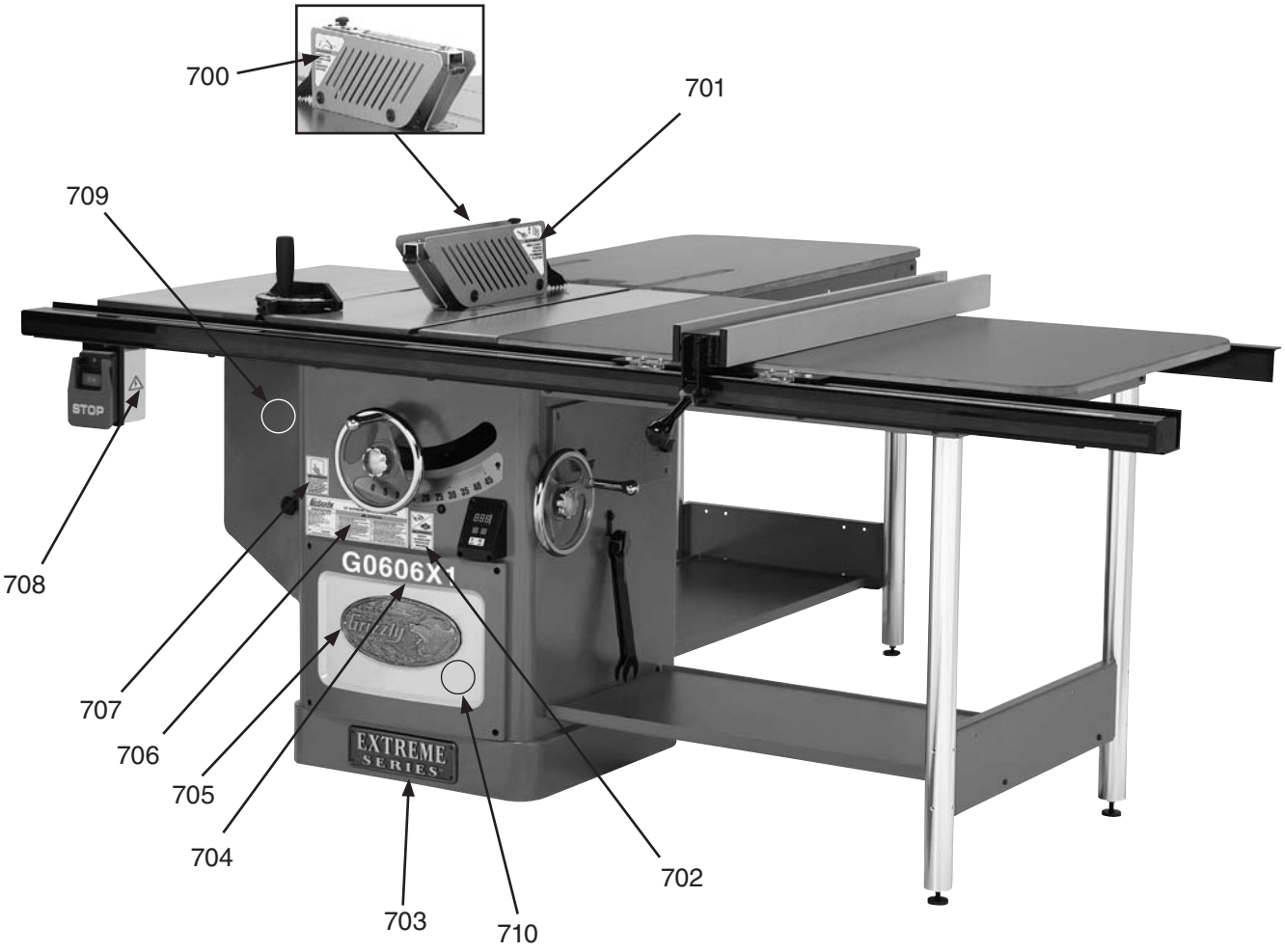
Outfeed Table (G0605X1/G0606X1)



REF	PART #	DESCRIPTION
600	P0605X600	OUTFEED TABLE ASSEMBLY
601	P0605X601	OUTFEED TABLE PLATE
602	P0605X602	OUTFEED TABLE SUPPORT
603	P0605X603	REAR OUTFEED TABLE BRACKET
604	P0605X604	SUPPORT LEG
605	P0605X605	FRONT OUTFEED TABLE BRACKET
606	P0605X606	LOWER SHELF
607	P0605X607	LOWER SHELF BRACKET
608	P0605X608	SHELF END PLATE

REF	PART #	DESCRIPTION
609	PHTEK6M	TAP SCREW M4 X 16
620	PS14M	PHLP HD SCR M6-1 X 12
621	PW03M	FLAT WASHER 6MM
622	PFB16M	FLANGE BOLT M8-1.25 X 16
623	PN03M	HEX NUT M8-1.25
624	PB02M	HEX BOLT M6-1 X 12
625	PN08	HEX NUT 3/8-16
626	P0605X626	FOOT 3/8-16 X 2
627	PN01M	HEX NUT M6-1

Labels



REF	PART #	DESCRIPTION
700	P0605X700	GUARD AND ANTI-KICK BACK LABEL
701	P0605X701	DISCONNECT PWR-BLADE CHANGE LABEL
702	PLABEL-57	GLASSES/RESPIRATOR LABEL
703	P0605X703	EXTREME SERIES PLATE
704	P0605X1704	MODEL # LABEL G0605X1
704	P0606X1704	MODEL # LABEL G0606X1
704	P0696X704	MODEL # LABEL G0696X
704	P0697X704	MODEL # LABEL G0697X
705	G8589	GRIZZLY NAMEPLATE-LARGE

REF	PART #	DESCRIPTION
706	P0605X1706	MACHINE ID LABEL G0605X1
706	P0606X1706	MACHINE ID LABEL G0606X1
706	P0696X706	MACHINE ID LABEL G0696X
706	P0697X706	MACHINE ID LABEL G0697X
707	PLABEL-12A	READ MANUAL-VERTICAL NS 7/05
708	PLABEL-14	ELECTRICITY LABEL
709	PPAINT-1	GRIZZLY GREEN PAINT
710	PPAINT-11	PUTTY TOUCH-UP PAINT

⚠WARNING

Safety labels warn about machine hazards and ways to prevent injury. The owner of this machine MUST maintain the original location and readability of the labels on the machine. If any label is removed or becomes unreadable, REPLACE that label before using the machine again. Contact Grizzly at (800) 523-4777 or www.grizzly.com to order new labels.

Grizzly Industrial, Inc. WARRANTY CARD

Name _____

Street _____

City _____ State _____ Zip _____

Phone # _____ Email _____ Invoice # _____

Model # _____ Order # _____ Serial # _____

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. ***Of course, all information is strictly confidential.***

1. How did you learn about us?

____ Advertisement ____ Friend ____ Catalog
____ Card Deck ____ Website ____ Other:

2. Which of the following magazines do you subscribe to?

____ Cabinet Maker
____ Family Handyman
____ Hand Loader
____ Handy
____ Home Shop Machinist
____ Journal of Light Cont.
____ Live Steam
____ Model Airplane News
____ Modeltec
____ Old House Journal
____ Popular Mechanics
____ Popular Science
____ Popular Woodworking
____ Practical Homeowner
____ Precision Shooter
____ Projects in Metal
____ RC Modeler
____ Rifle
____ Shop Notes
____ Shotgun News
____ Today's Homeowner
____ Wood
____ Wooden Boat
____ Woodshop News
____ Woodsmith
____ Woodwork
____ Woodworker West
____ Woodworker's Journal
____ Other:

3. What is your annual household income?

____ $20,000-$29,000 ____ $30,000-$39,000 ____ $40,000-$49,000
____ $50,000-$59,000 ____ $60,000-$69,000 ____ $70,000+

4. What is your age group?

____ 20-29 ____ 30-39 ____ 40-49
____ 50-59 ____ 60-69 ____ 70+

5. How long have you been a woodworker/metalworker?

____ 0-2 Years ____ 2-8 Years ____ 8-20 Years ____ 20+ Years

6. How many of your machines or tools are Grizzly?

____ 0-2 ____ 3-5 ____ 6-9 ____ 10+

7. Do you think your machine represents a good value? _____ Yes _____ No

8. Would you recommend Grizzly Industrial to a friend? _____ Yes _____ No

9. Would you allow us to use your name as a reference for Grizzly customers in your area?
Note: *We never use names more than 3 times.* _____ Yes _____ No

10. Comments: _____

_____

_____

_____

CUT ALONG DOTTED LINE

FOLD ALONG DOTTED LINE

Place
Stamp
Here

GRIZZLY INDUSTRIAL, INC.
P.O. BOX 2069
BELLINGHAM, WA 98227-2069

FOLD ALONG DOTTED LINE

Send a Grizzly Catalog to a friend:

Name_____

Street_____

City_____State_____Zip_____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE

WARRANTY AND RETURNS

Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number,'' which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.

grizzly.com®

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